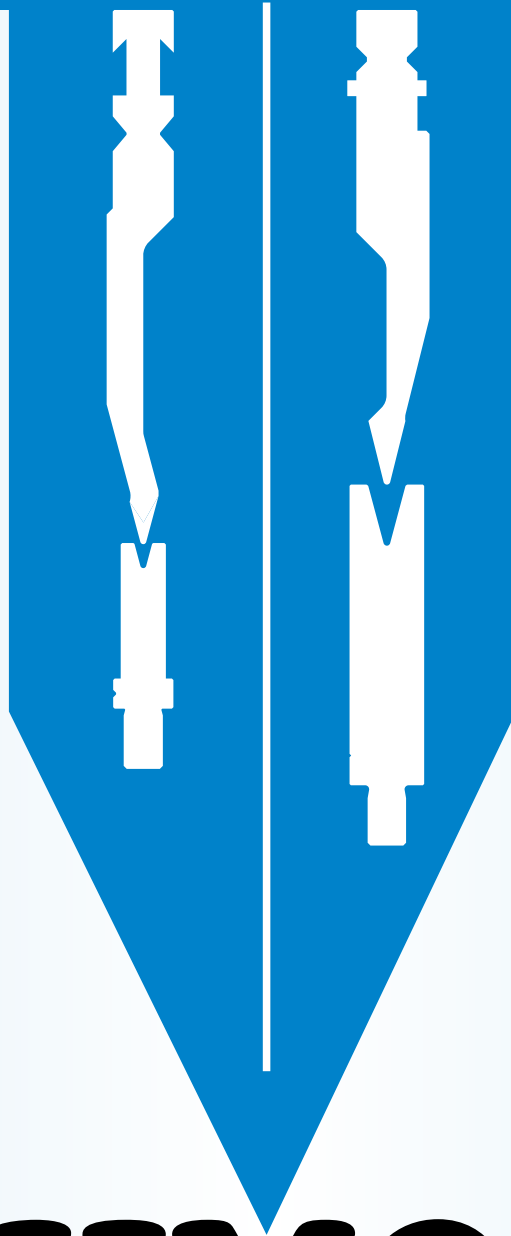


HI-TECH TOOLS

TRUMPF/BYSTRONIC RANGE

**Large stocks
available for
immediate
despatch**

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Compatibility
with OEM**



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suit all types
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Ashmores are the UK's longest established Press Brake Tool manufacturer established in 1919. We offer Press Brake Tooling to suit all models of press brake: the range includes tools to suit all Euro style machines, Trumpf / Wila, Bystronic, LVD and many more. Large stocks are held where we can offer an immediate response to urgent orders. We can also offer technical advice and back up from our design team. In addition we are able to offer Guillotine Blades for all machines together with a re-grinding service. Our aim is to offer all customers an economical solution to their bending problems with quick response time and deliveries.

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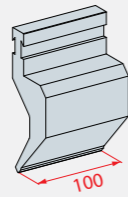
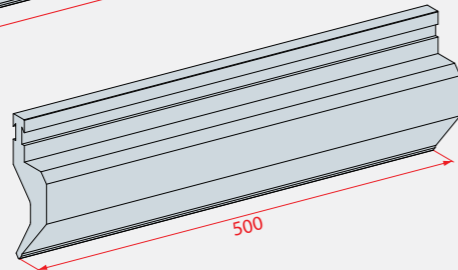
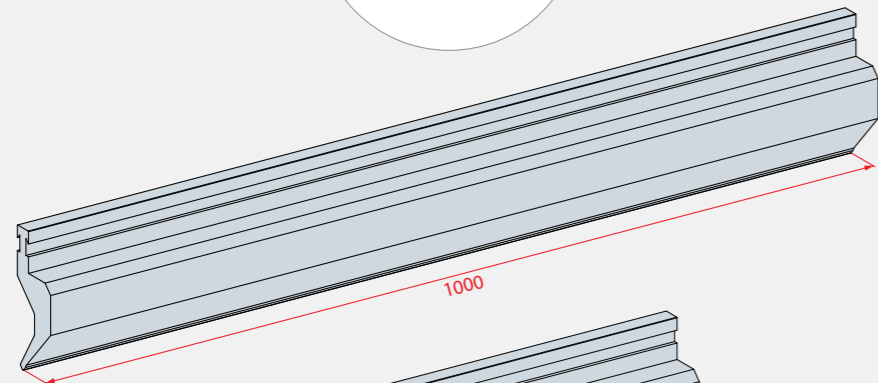
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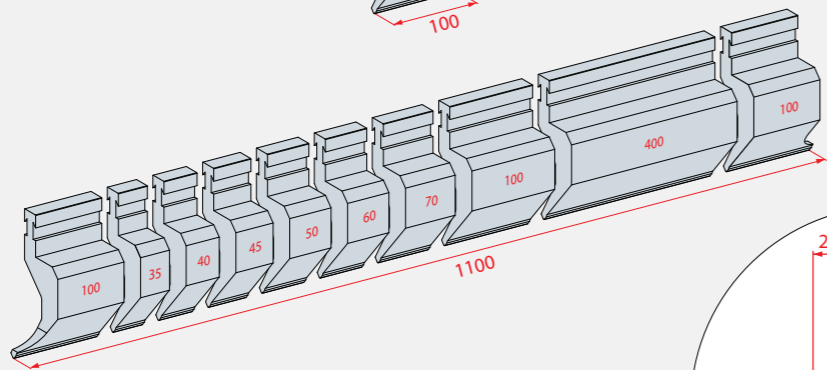
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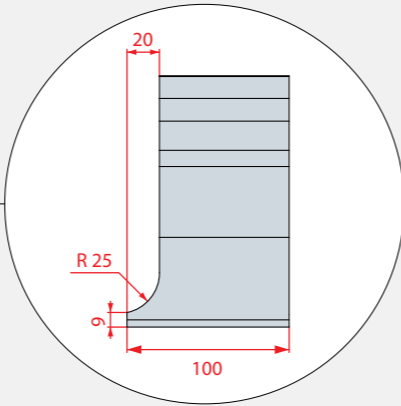
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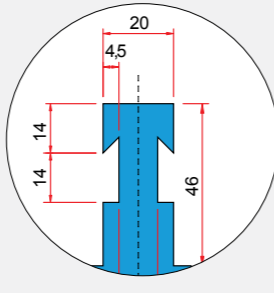
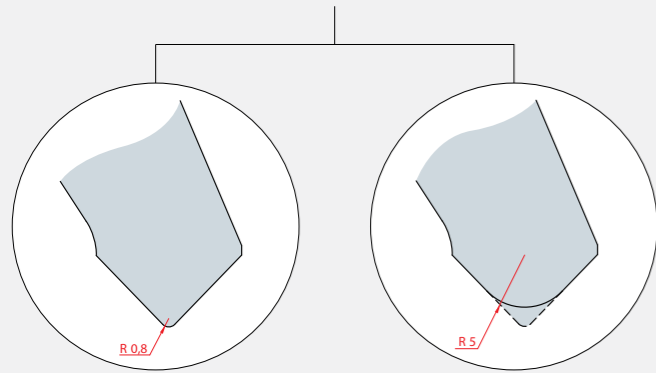
STANDARD
SECTIONING



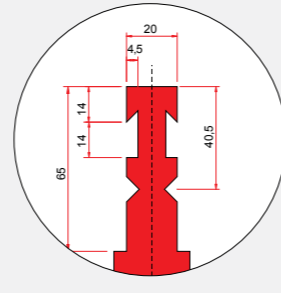
MILLING HORN



MODIFICATION RADIUS

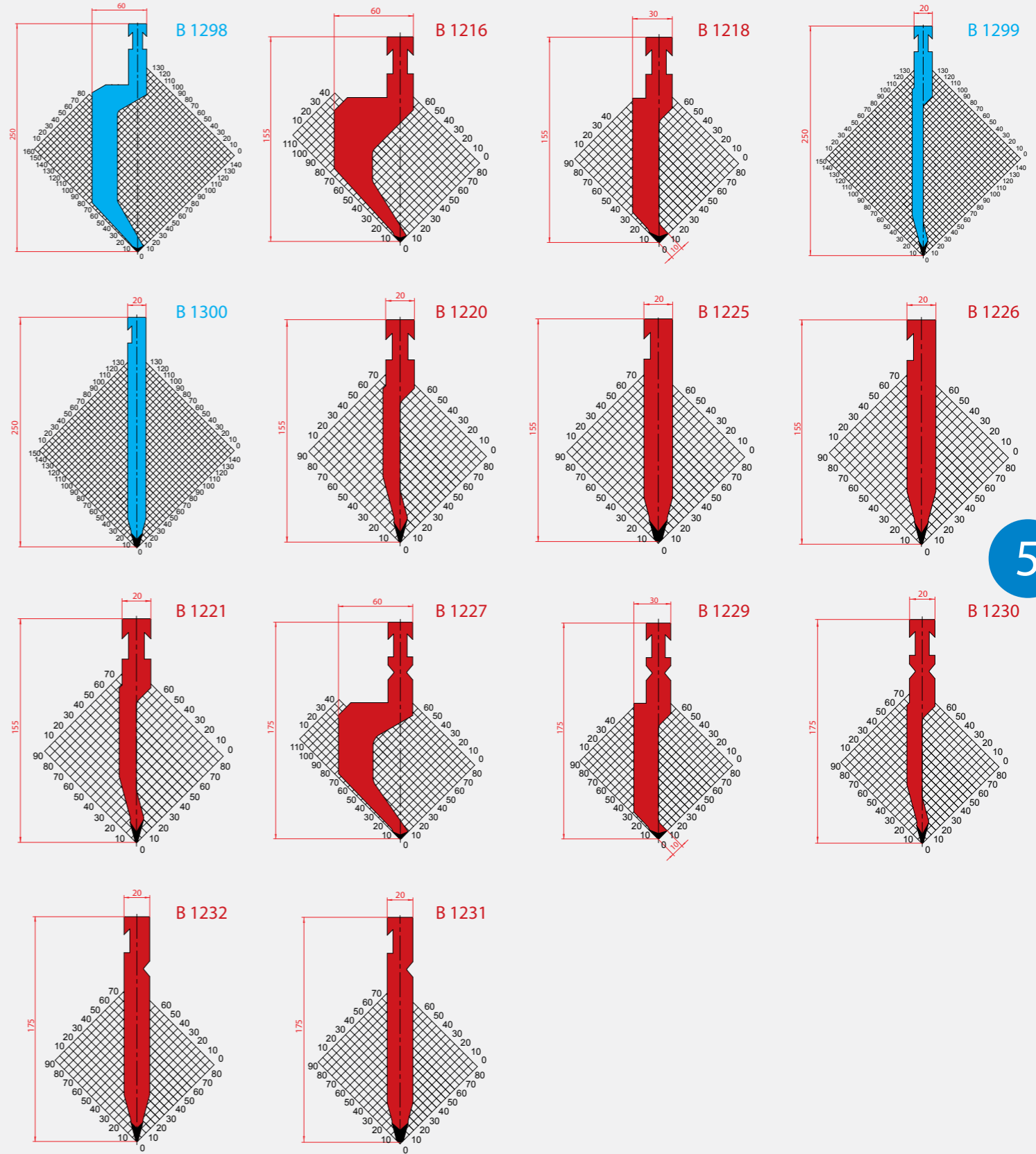


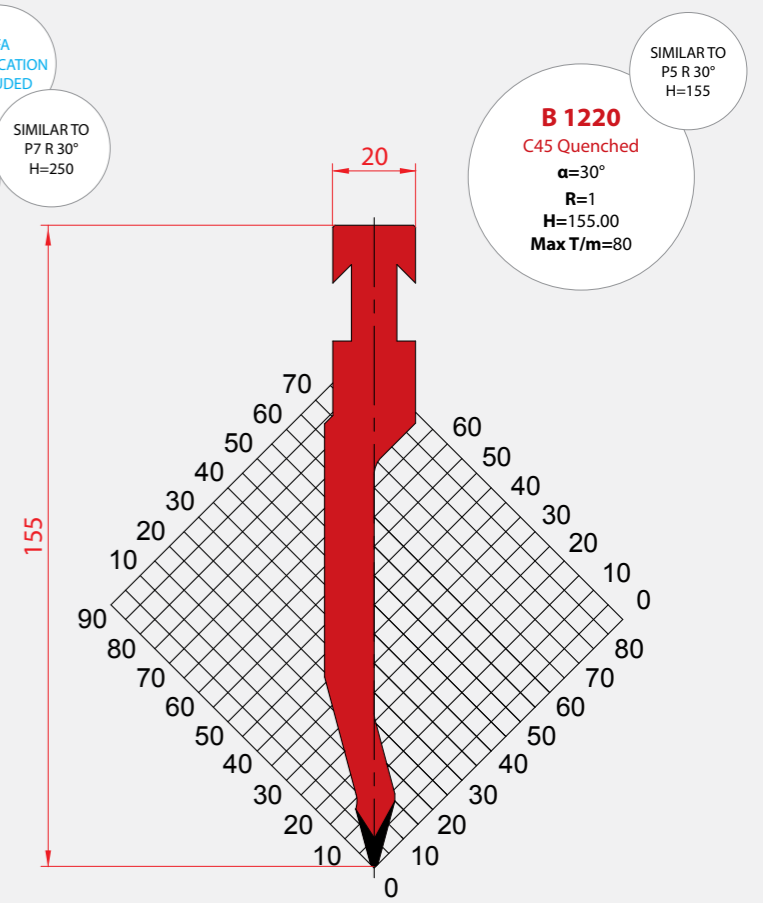
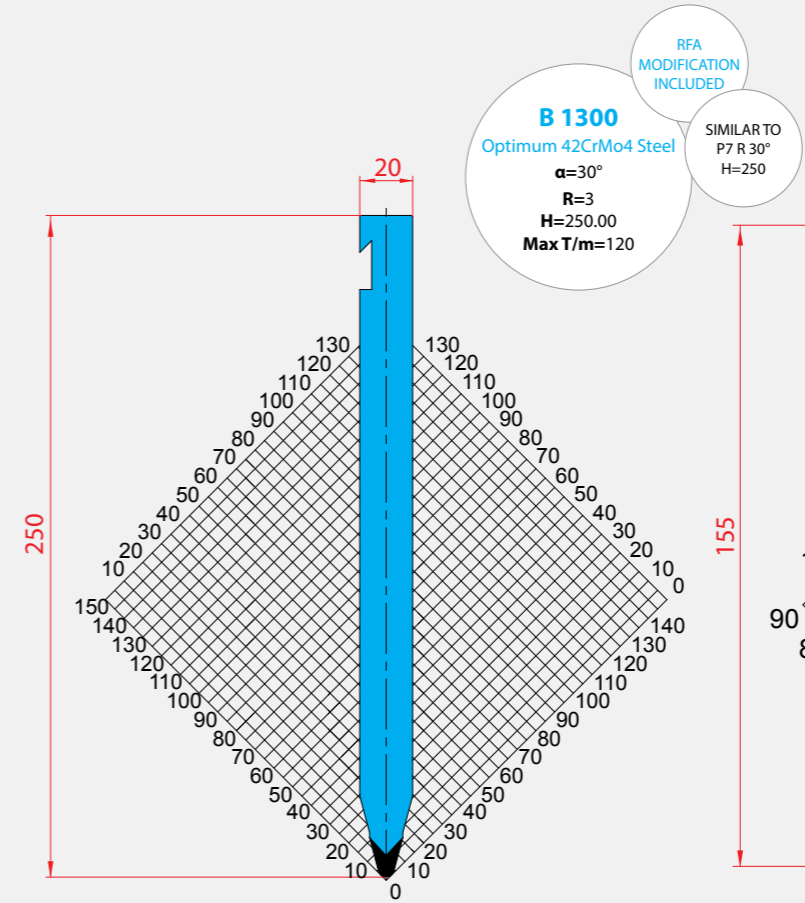
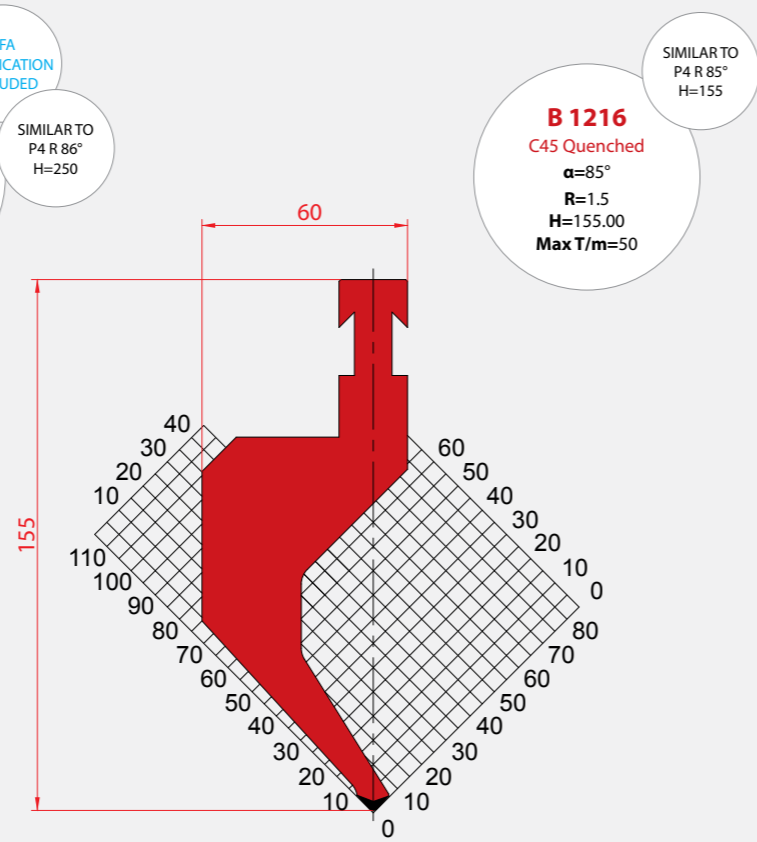
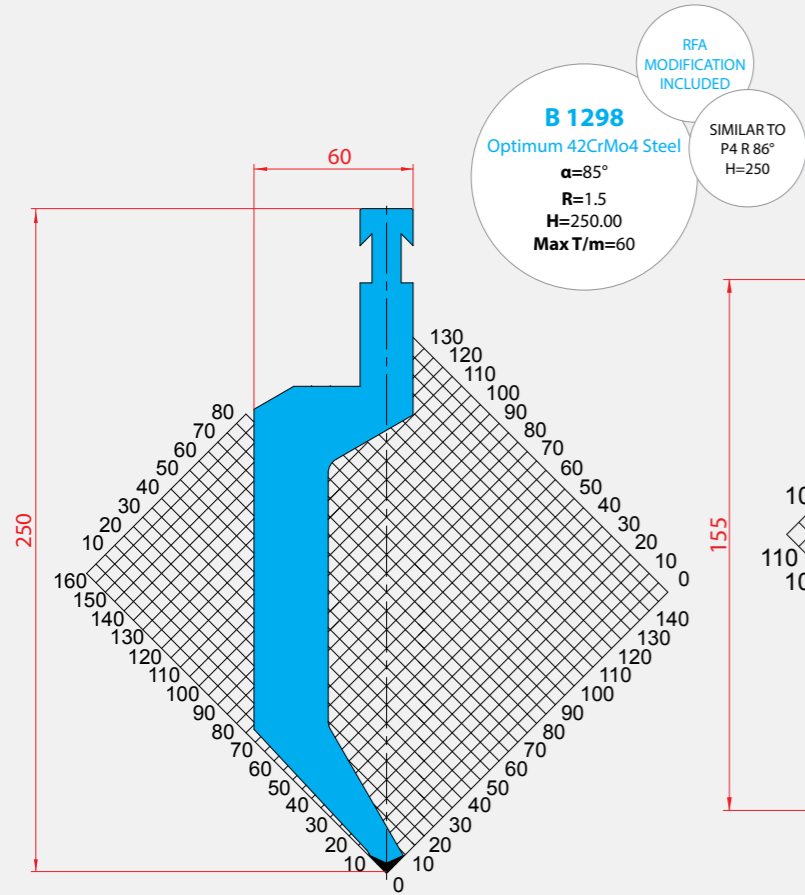
BYSTRONIC R
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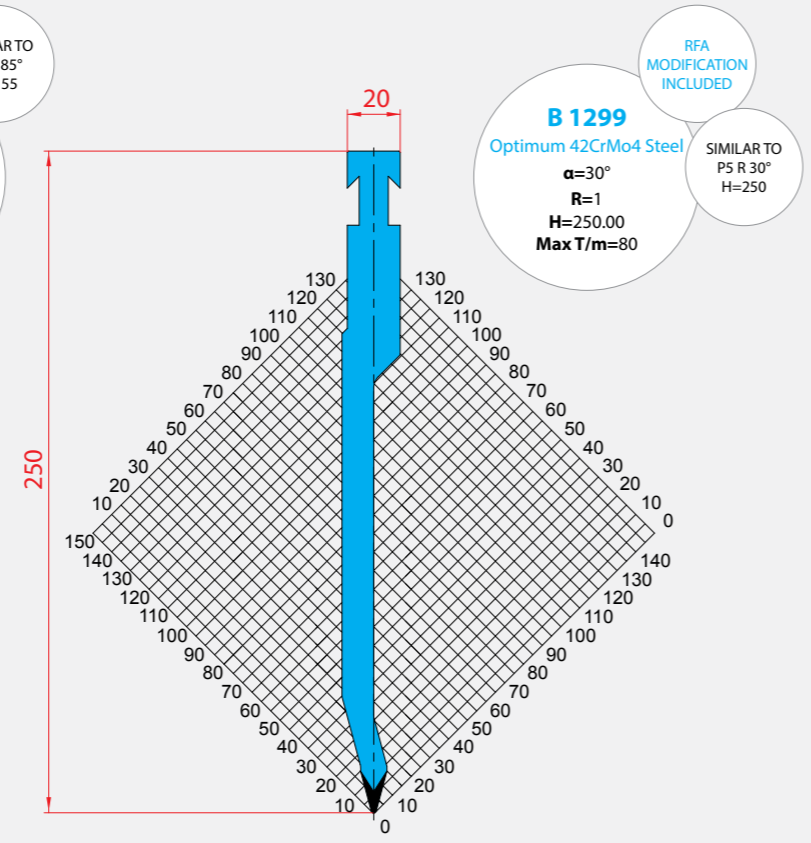
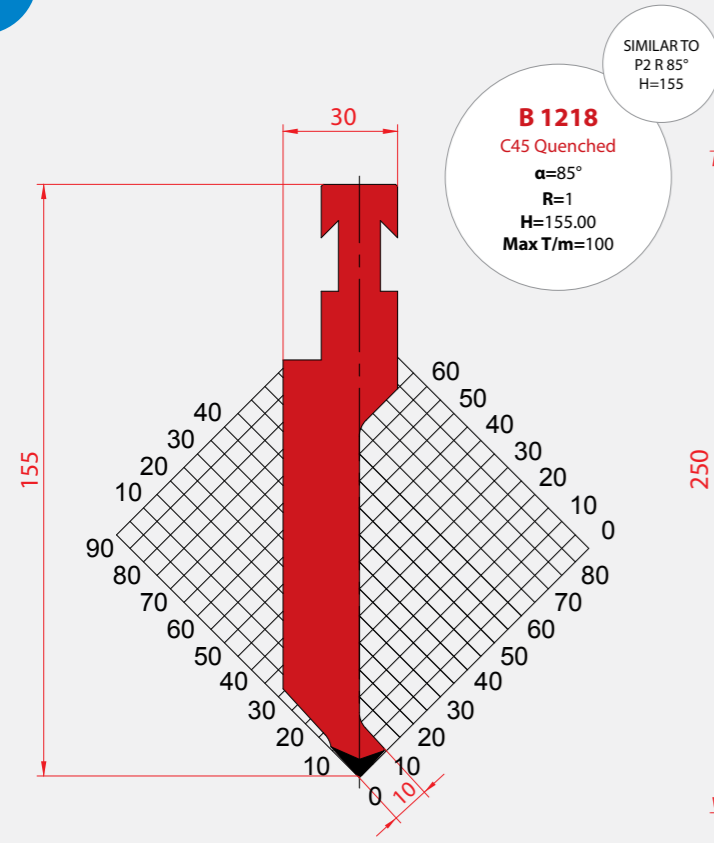
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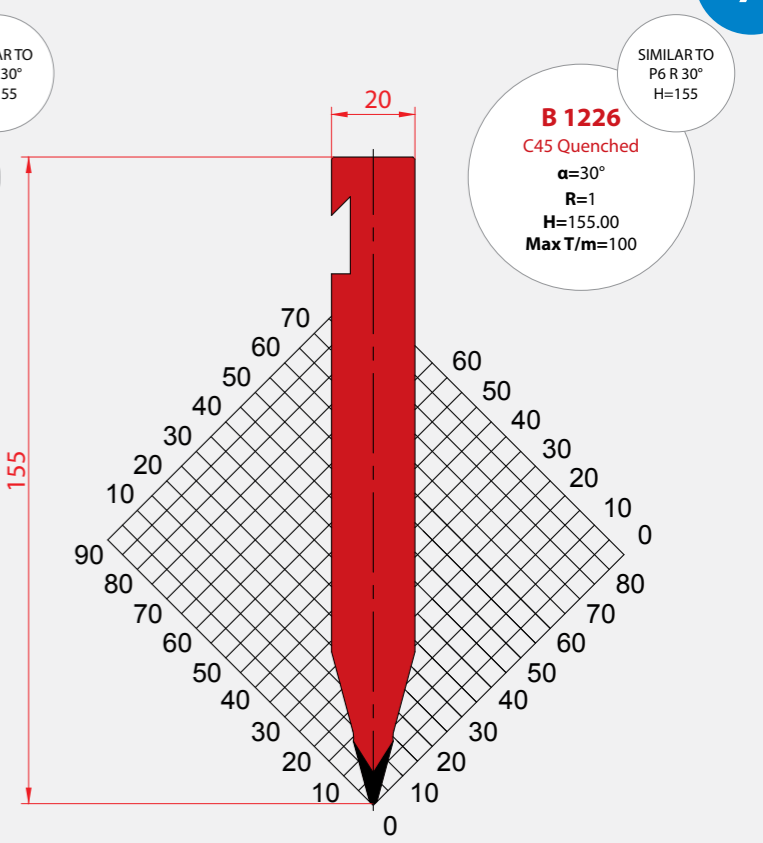
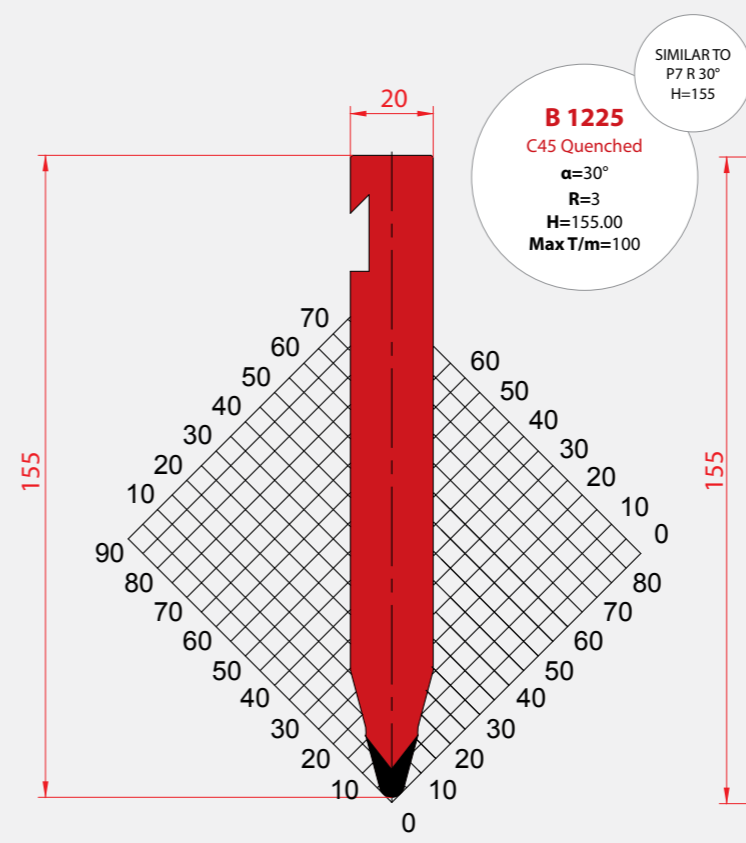


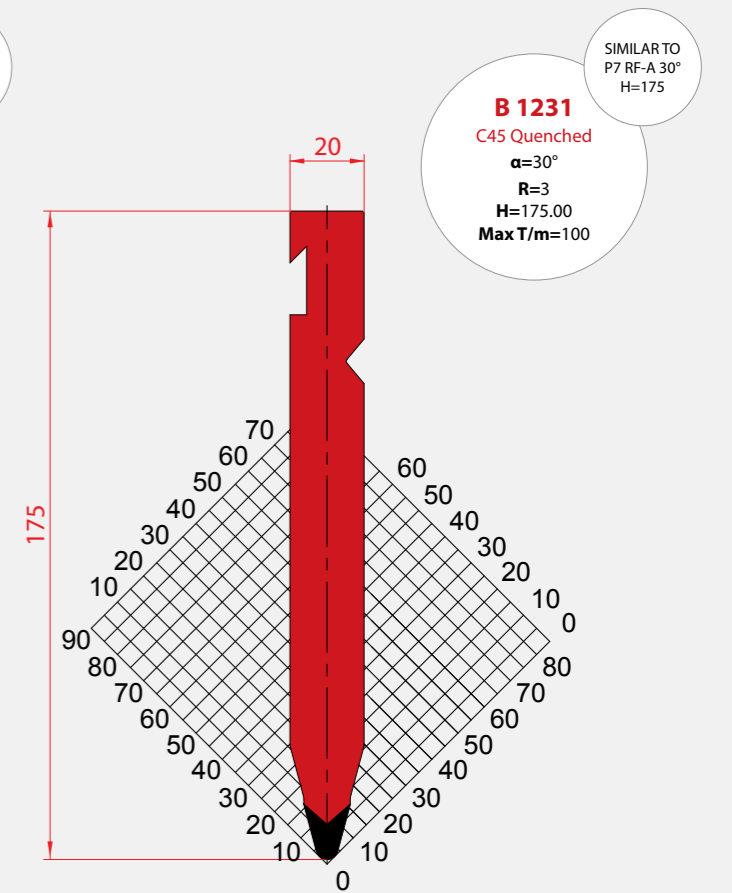
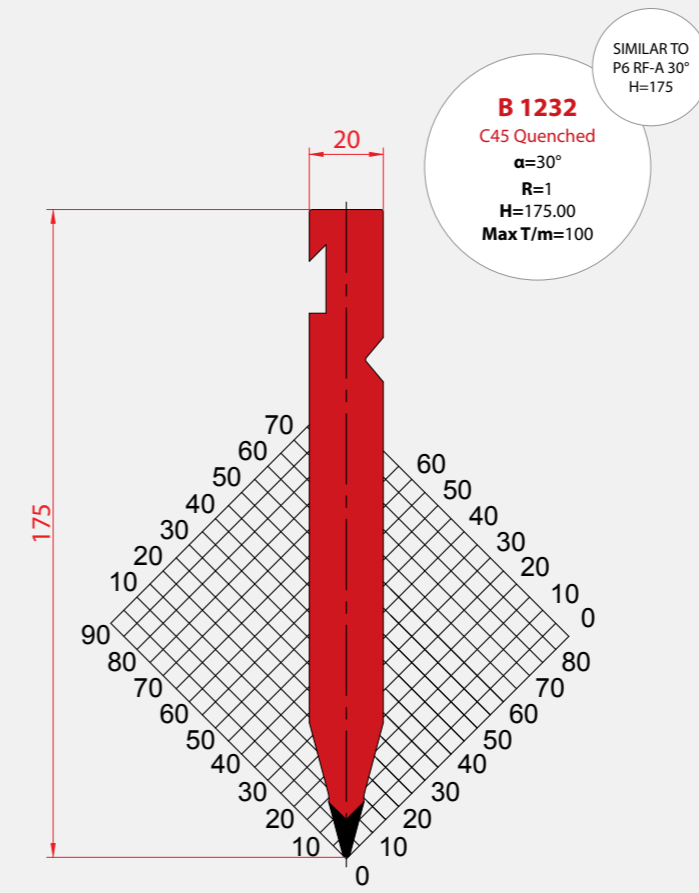
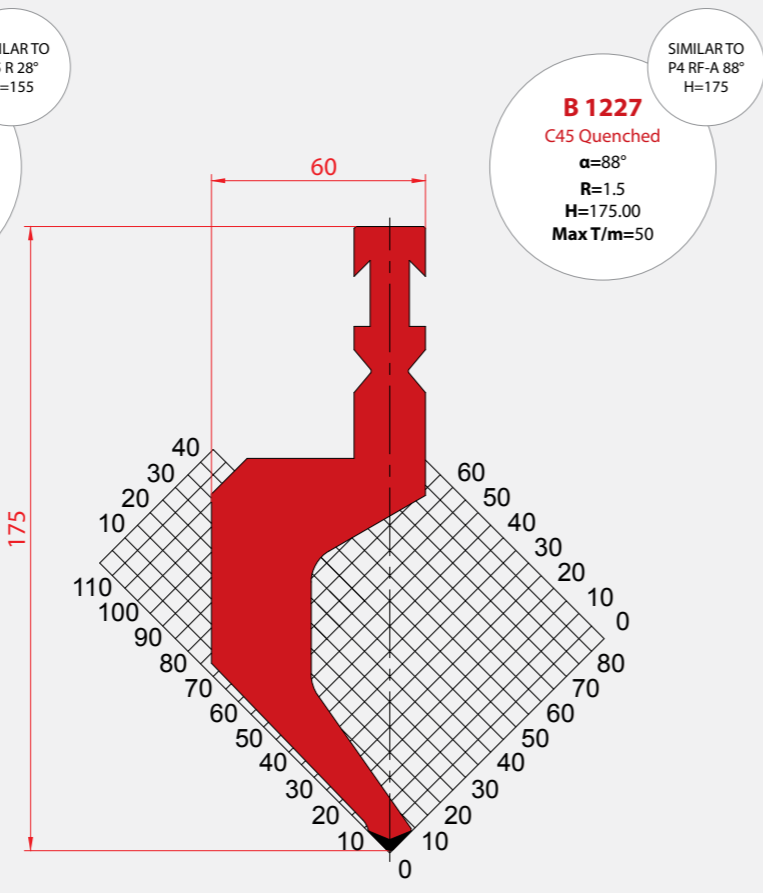
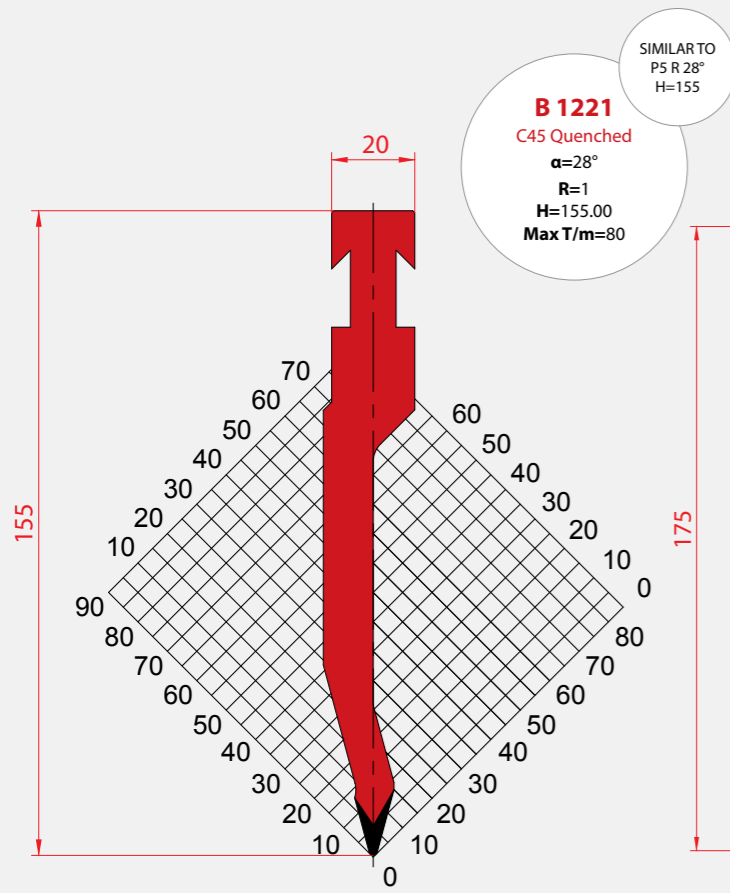


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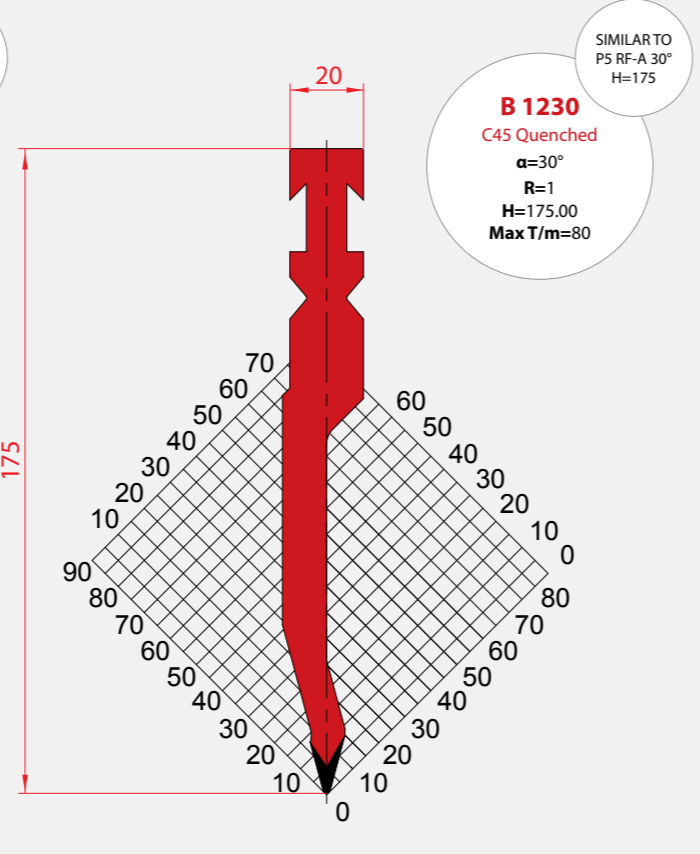
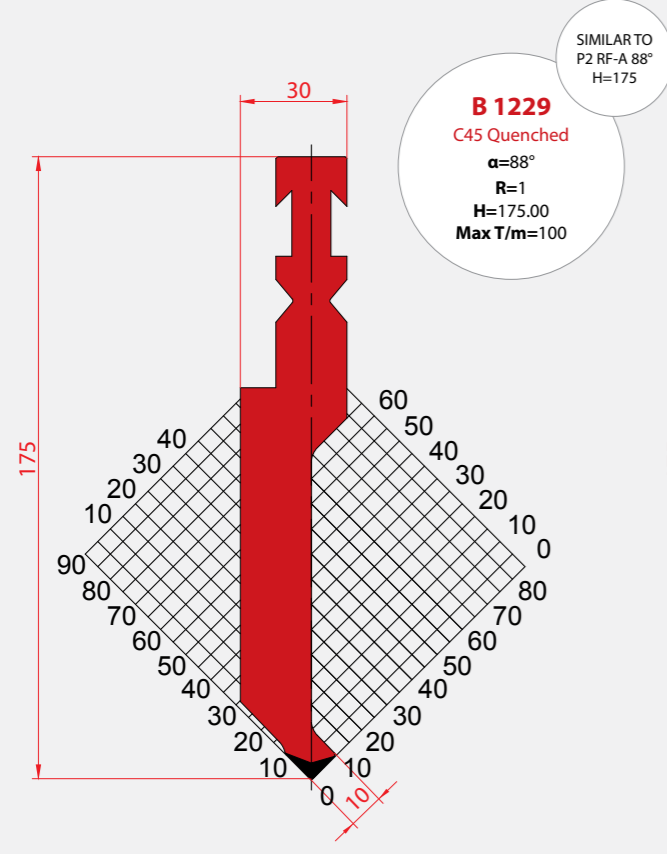


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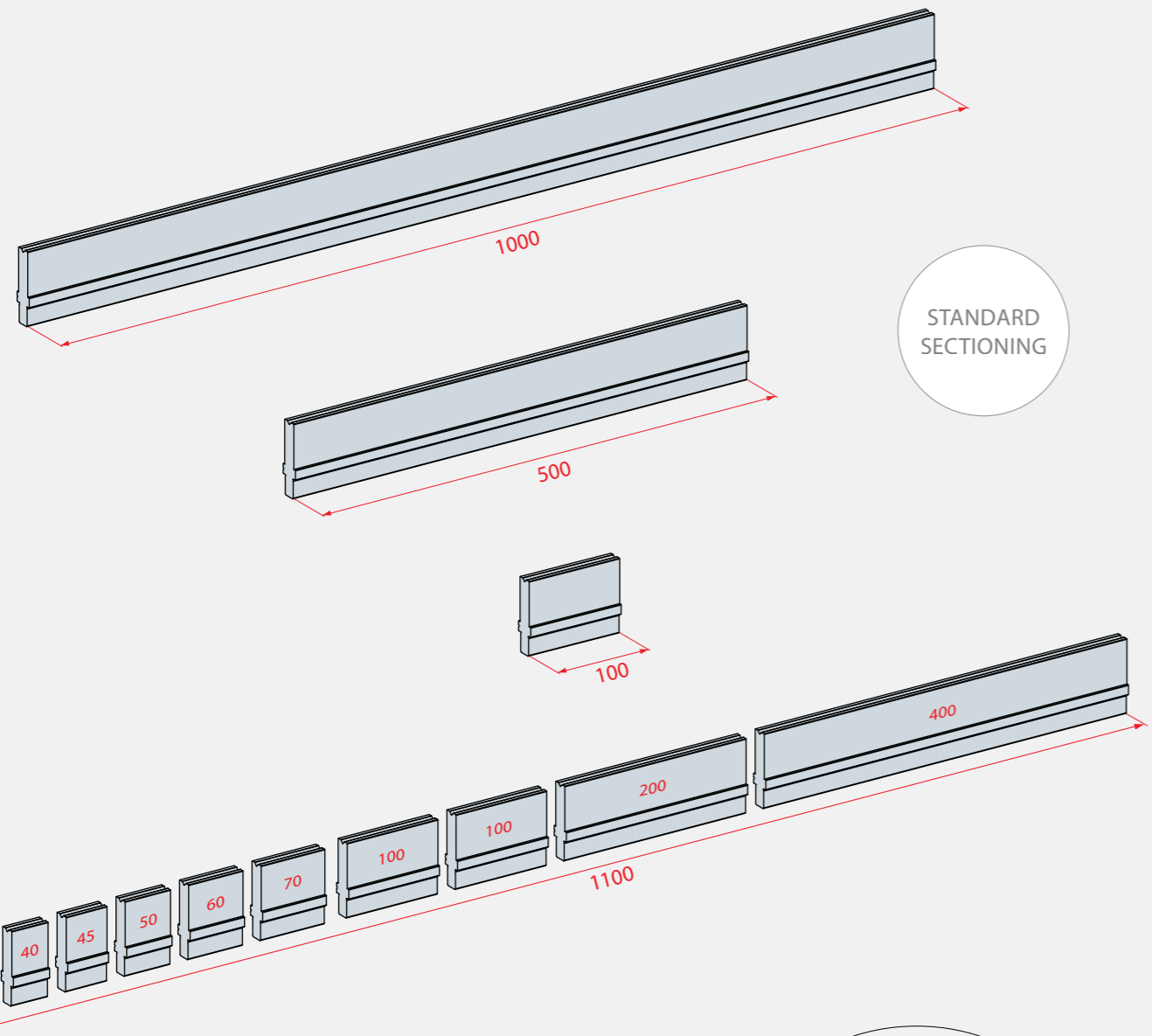
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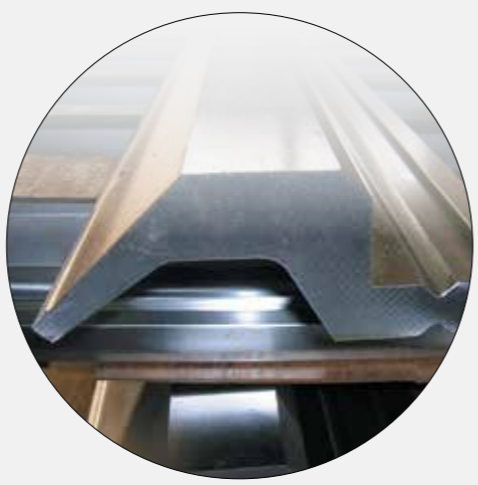
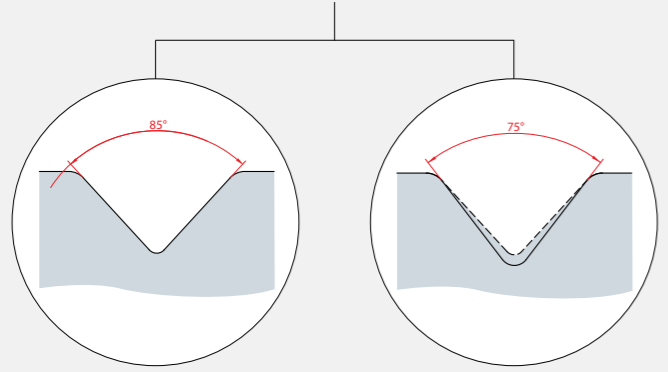
DIES
BYSTRONIC RANGE



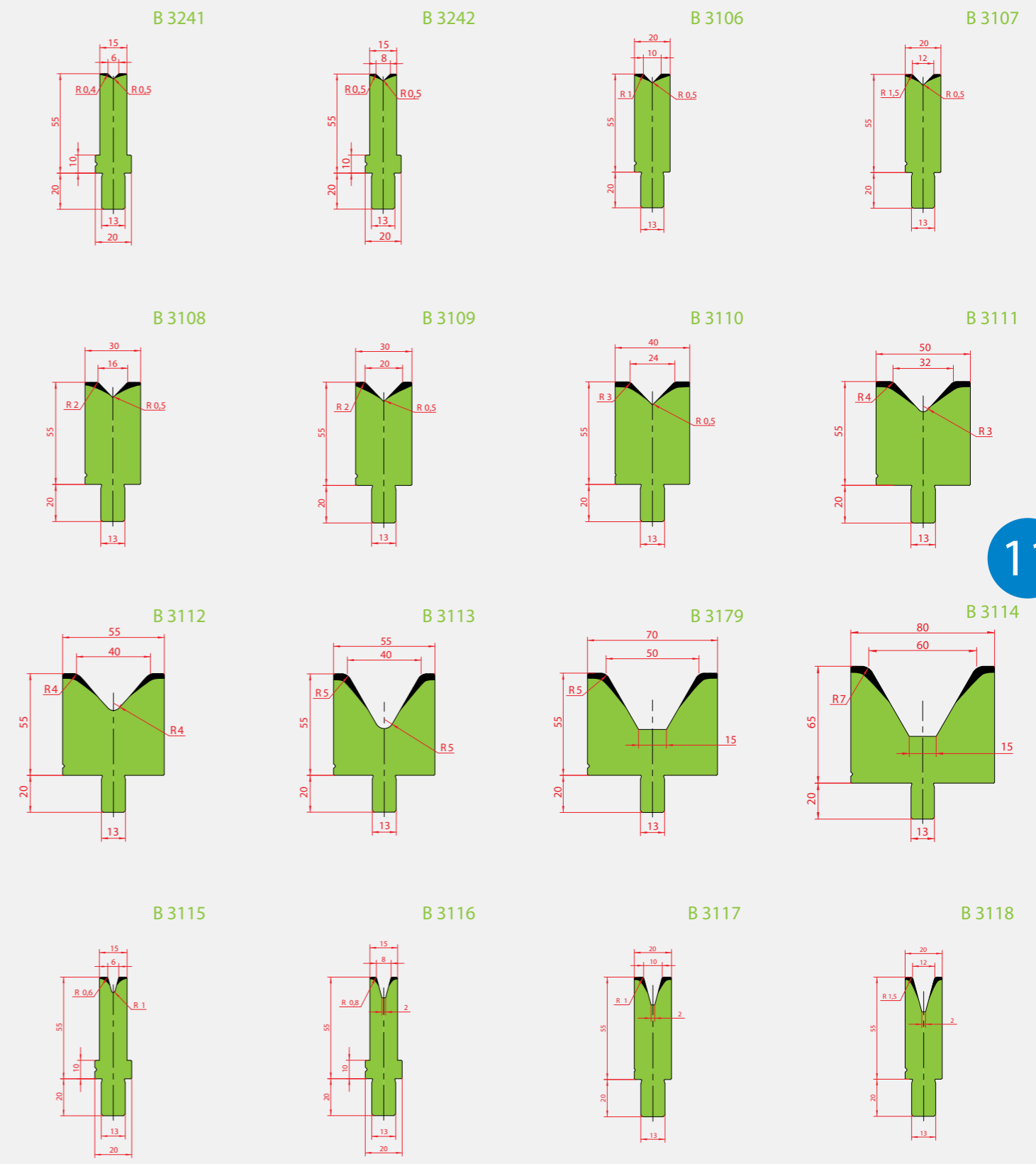
STANDARD SECTIONING

10

MODIFICATION ANGLES

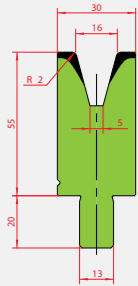


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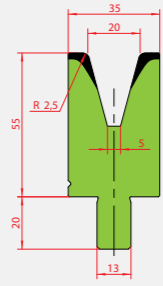


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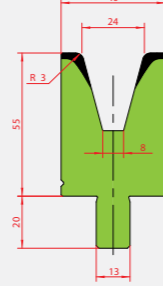
B 3119



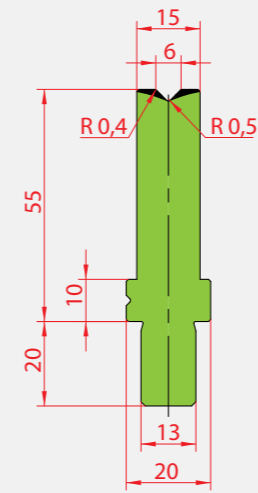
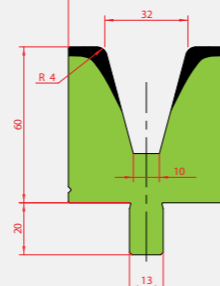
B 3120



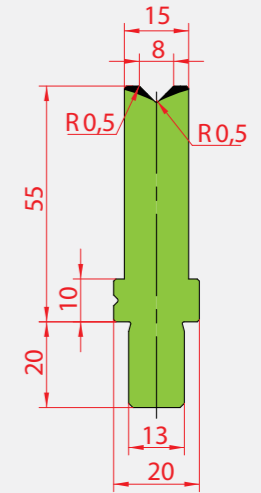
B 3121



B 3122

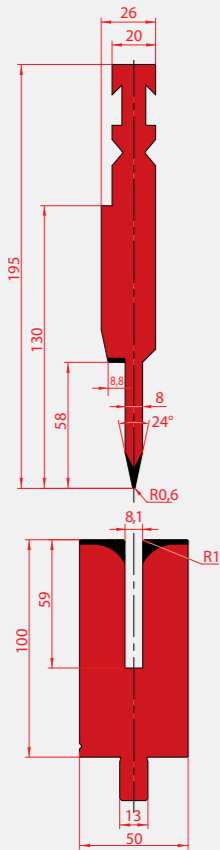


B 3241
Standard C45
Max T/m=100

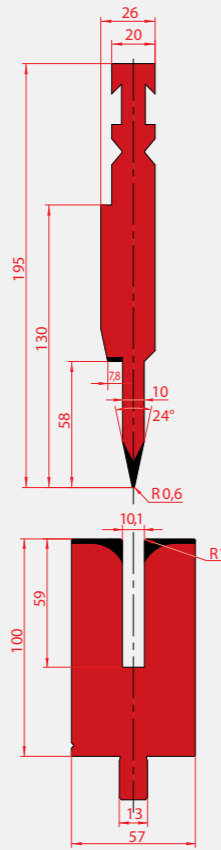


B 3242
Standard C45
Max T/m=100

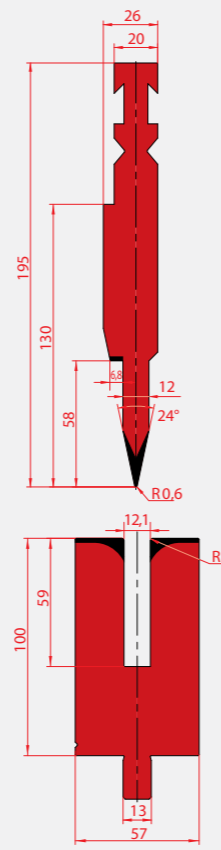
B 1252



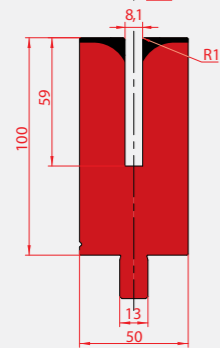
B 1253



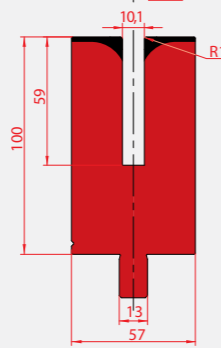
B 1254



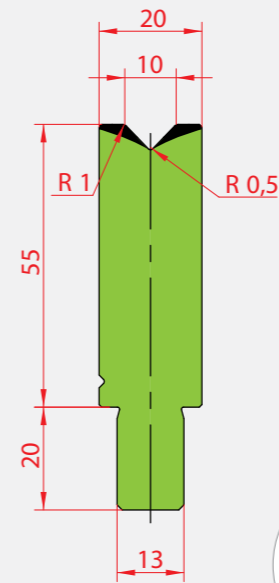
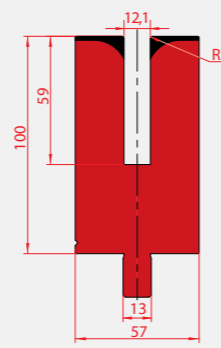
B 3157



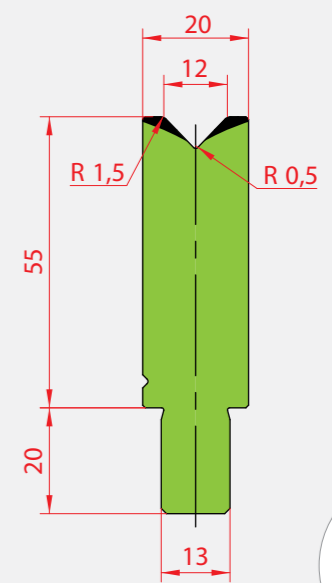
B 3174



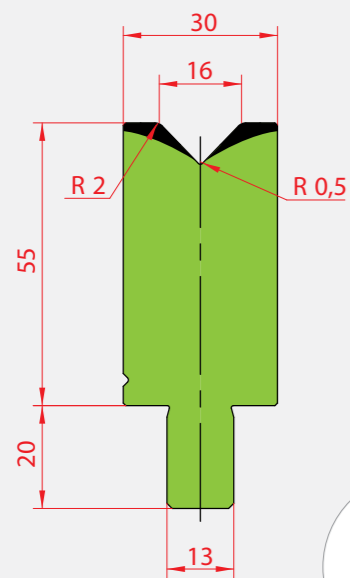
B 3175



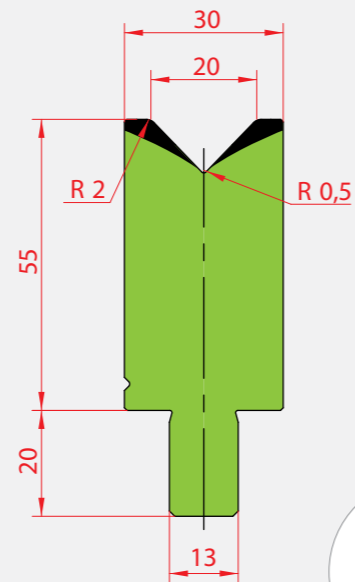
B 3106
Standard C45
Max T/m=100



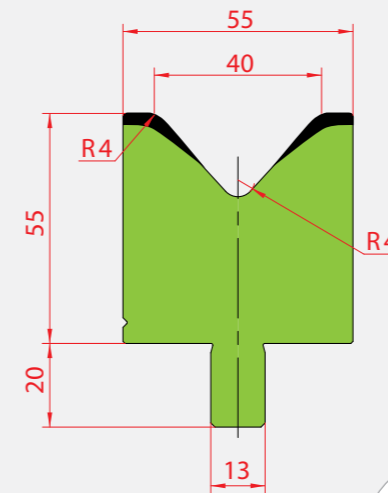
B 3107
Standard C45
Max T/m=100



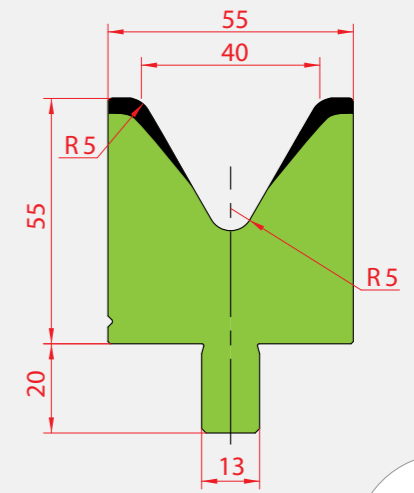
B 3108
Standard C45
Max T/m=100



B 3109
Standard C45
Max T/m=100

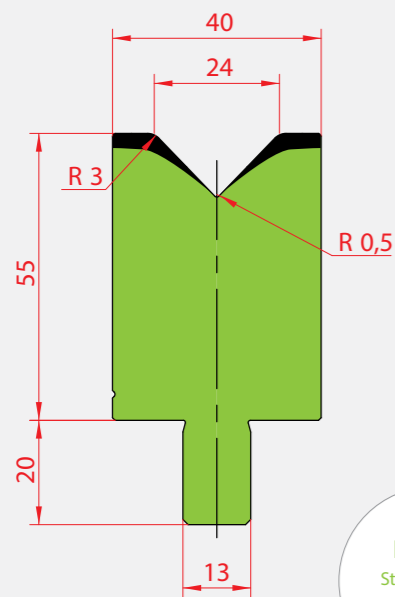


B 3112
Standard C45
Max T/m=100

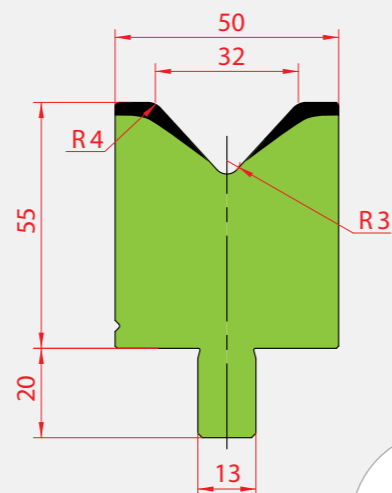


B 3113
Standard C45
Max T/m=100
SIMILAR TO V40/60°

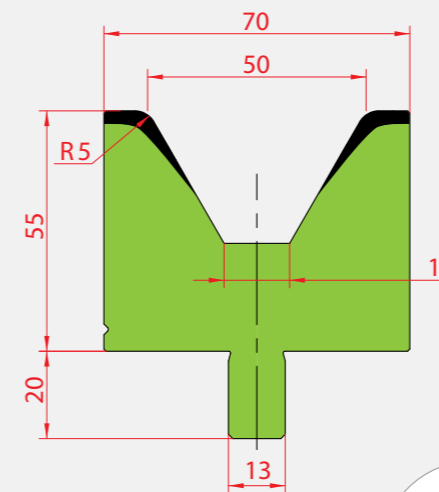
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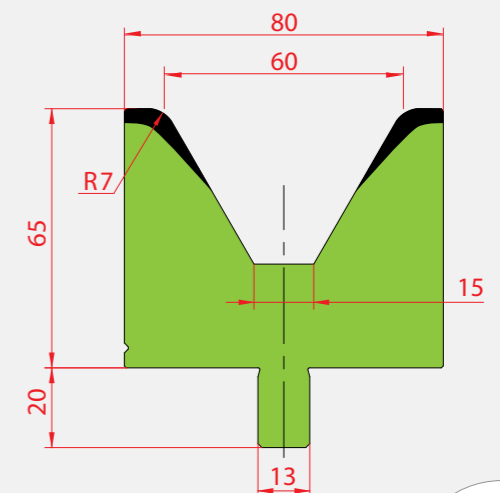
B 3110
Standard C45
Max T/m=100



B 3111
Standard C45
Max T/m=100

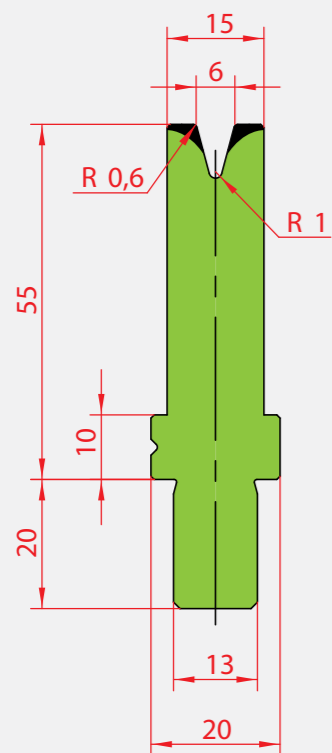


B 3179
Standard C45
Max T/m=100
SIMILAR TO V50/60°



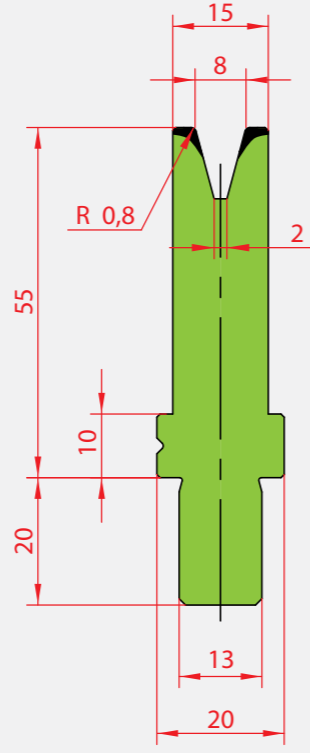
B 3114
Standard C45
Max T/m=100
SIMILAR TO V60/60°

15



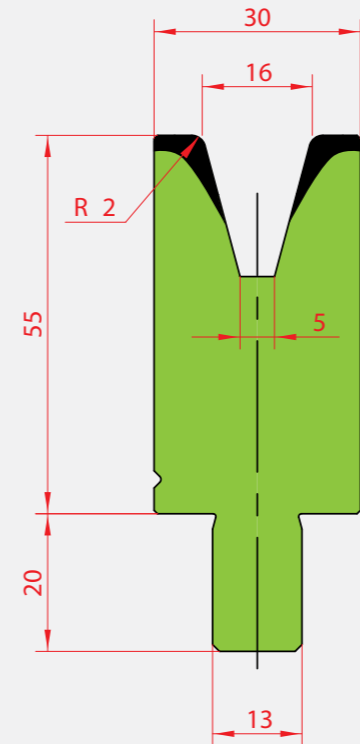
B 3115
Standard C45
Max T/m=35

SIMILARTO
V6/30°



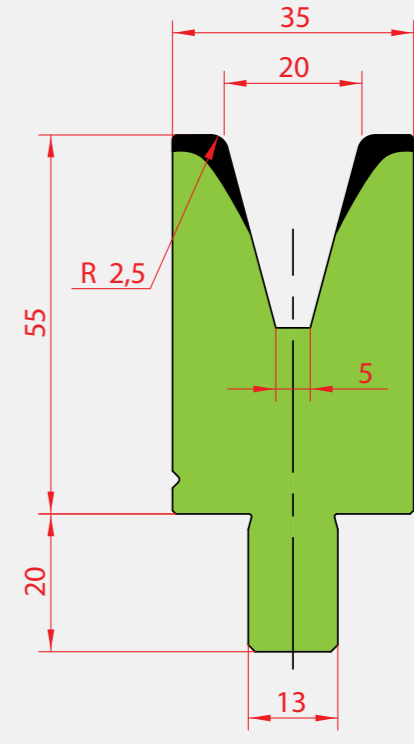
B 3116
Standard C45
Max T/m=40

SIMILARTO
V8/30°



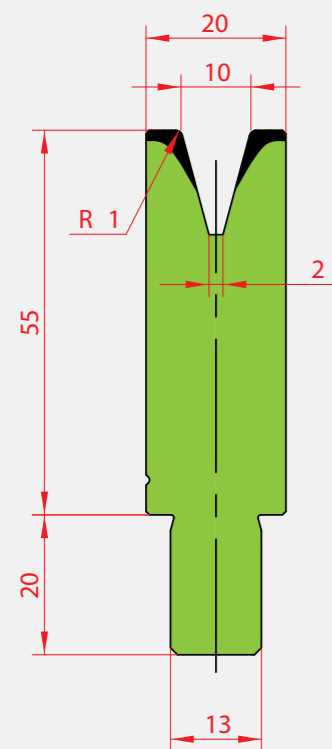
B 3119
Standard C45
Max T/m=50

SIMILARTO
V16/30°



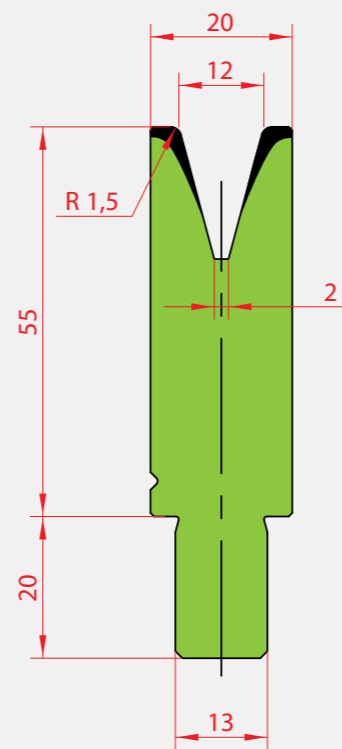
B 3120
Standard C45
Max T/m=55

SIMILARTO
V20/30°



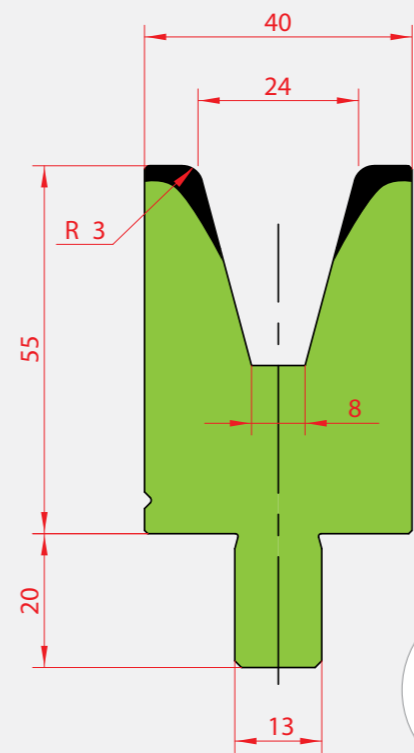
B 3117
Standard C45
Max T/m=50

SIMILARTO
V10/30°



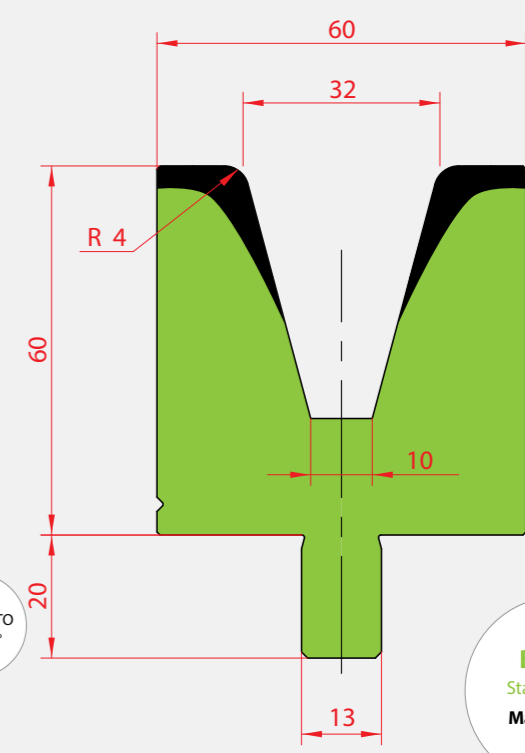
B 3118
Standard C45
Max T/m=40

SIMILARTO
V12/30°



B 3121
Standard C45
Max T/m=65

SIMILARTO
V24/30°

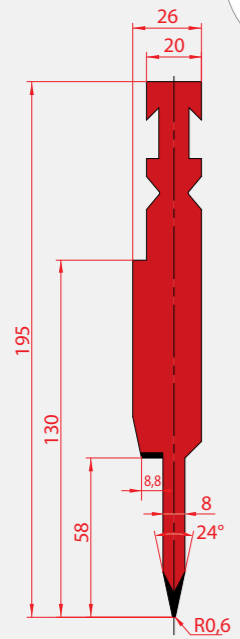


B 3122
Standard C45
Max T/m=65

SIMILARTO
V32/30°

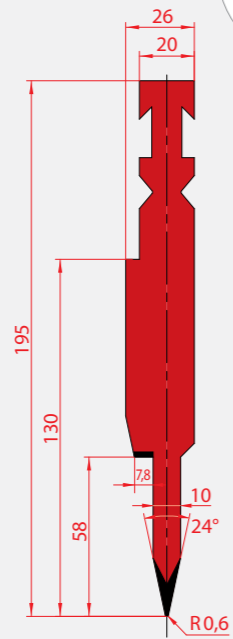
FLATTENING/
HEMMING
TOOLS

B 1252
C45 Quenched
Max T/m=80



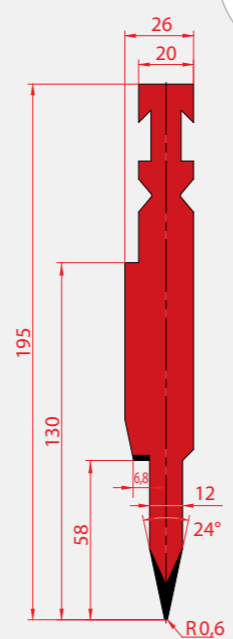
Max sheet thickness mild steel 1,2 mm

B 1253
C45 Quenched
Max T/m=80



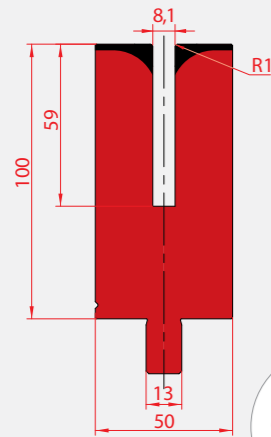
Max sheet thickness mild steel 1,2 mm

B 1254
C45 Quenched
Max T/m=80

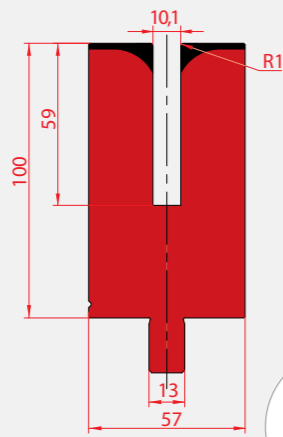


Max sheet thickness mild steel 1,2 mm

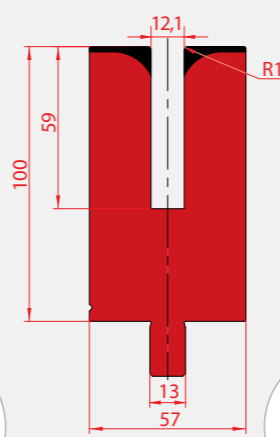
B 3157
C45 Quenched
Max T/m=50



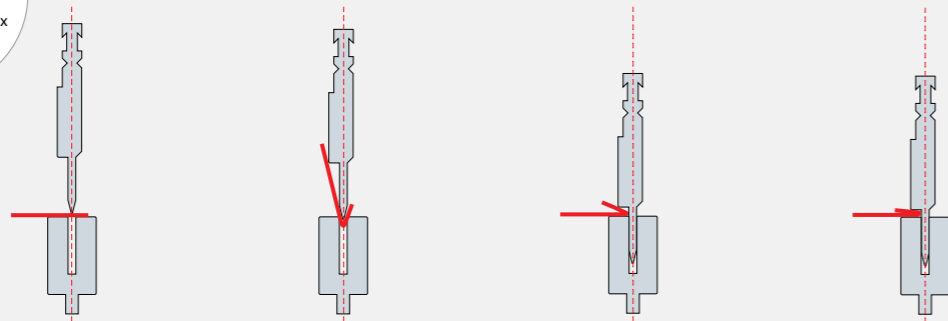
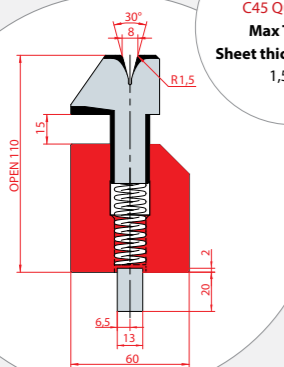
B 3174
C45 Quenched
Max T/m=50



B 3175
C45 Quenched
Max T/m=50

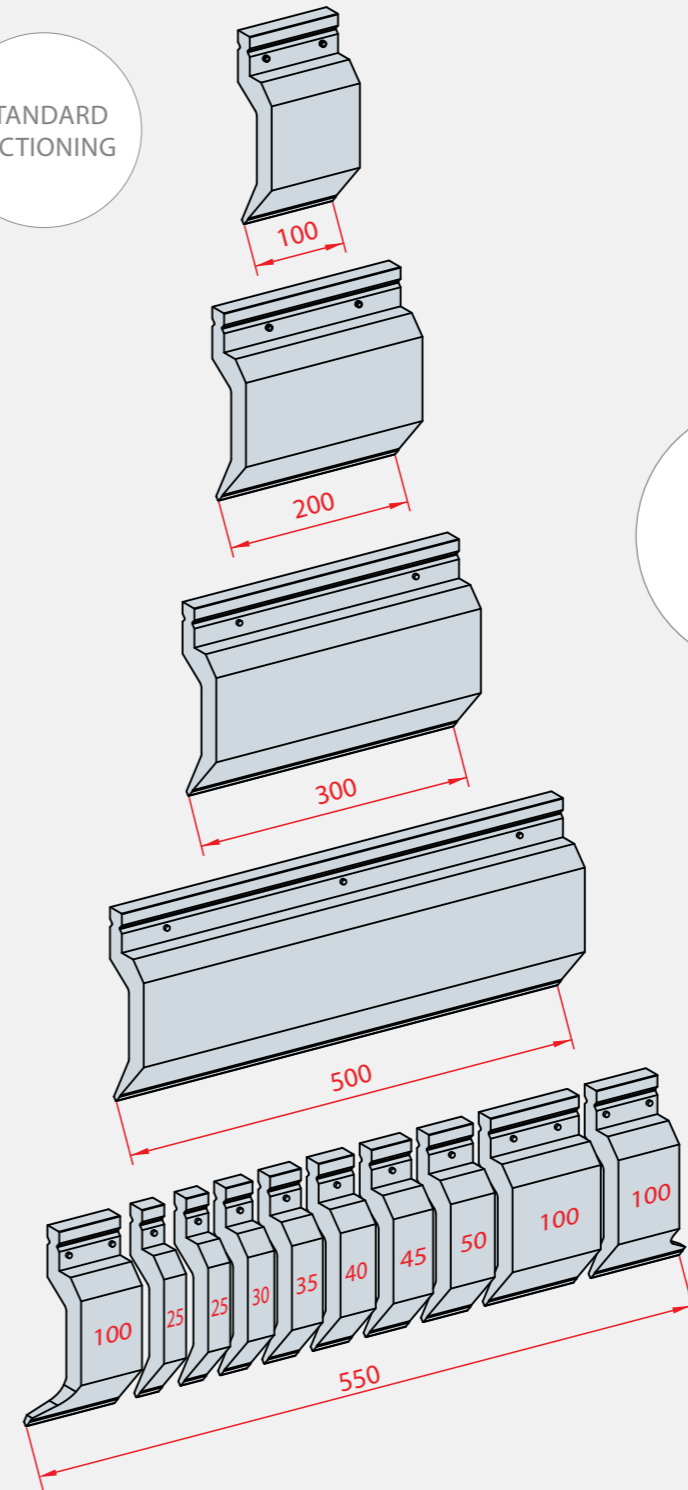


B 3041
C45 Quenched
Max T/m=80
Sheet thickness= max 1,5 mm

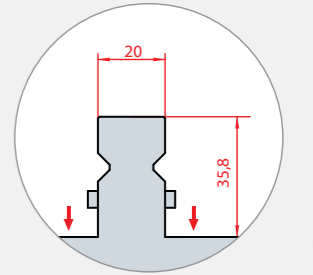
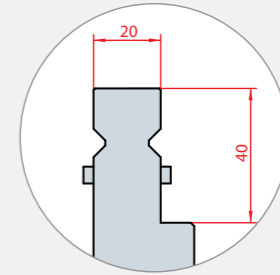
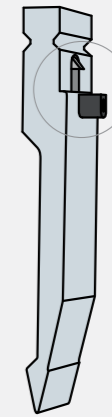


PUNCHES
TRUMPF RANGE

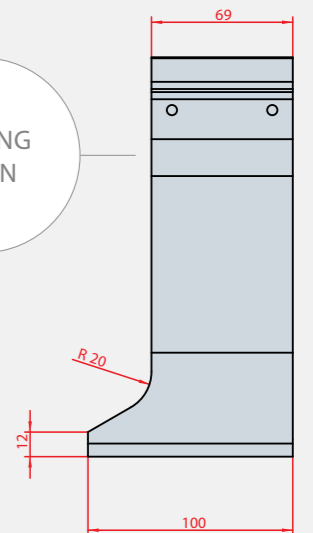
STANDARD
SECTIONING



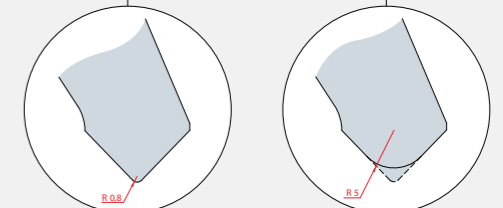
SAFETY BUTTON
AVAILABLE ON
REQUEST WHEN
THE WEIGHT OF
THE PUNCH IS LESS
THAN 12.5Kg



MILLING
HORN



MODIFICATION RADIUS



FOR PUNCHES:
1233 - 1234 - 1235
1236 - 1237 - 1238
1295 - 1302 - 1308
1313 - 1314

L	550	200	300	500
550	1	-	-	-
1050	1	1	1	-
1250	1	2	1	-
2050	1	1	1	2
2550	1	1	1	3
3050	1	1	1	4
4050	1	1	1	6

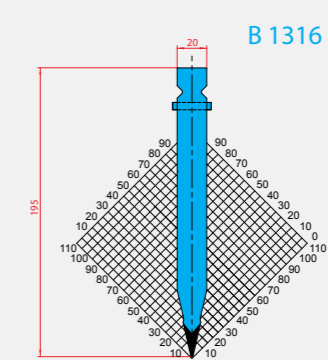
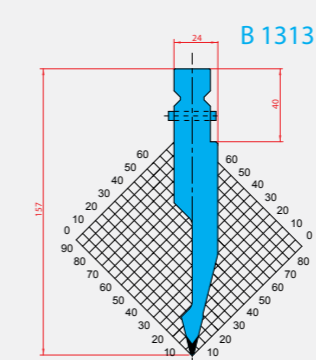
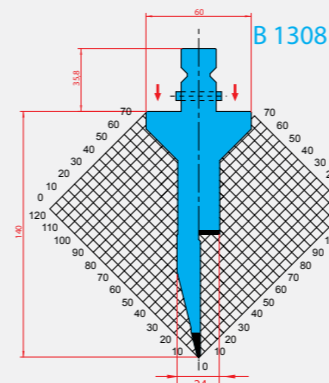
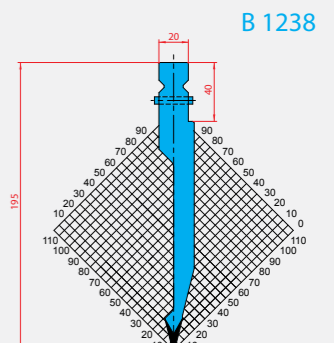
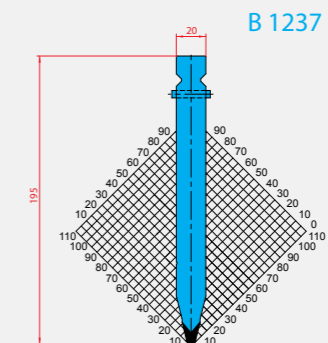
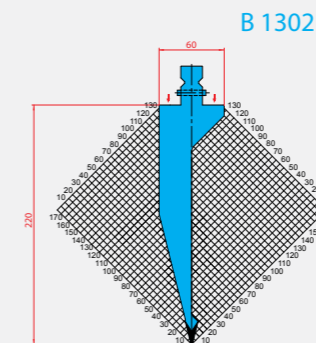
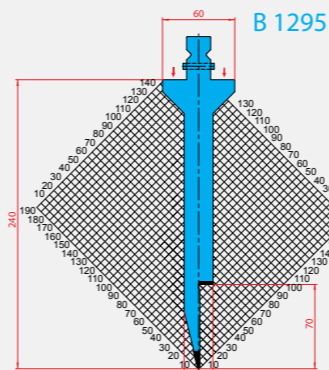
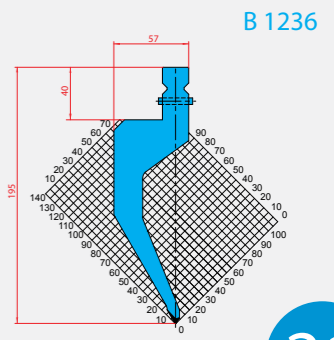
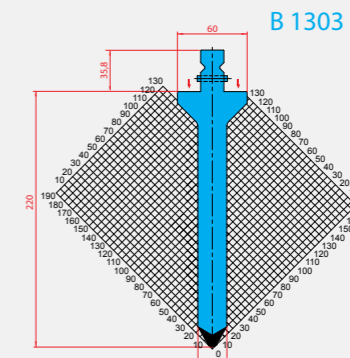
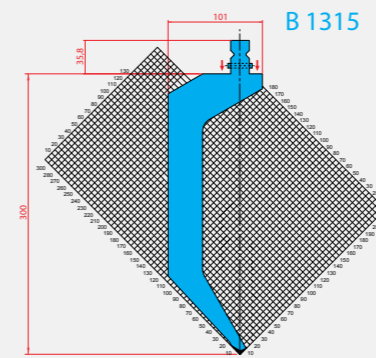
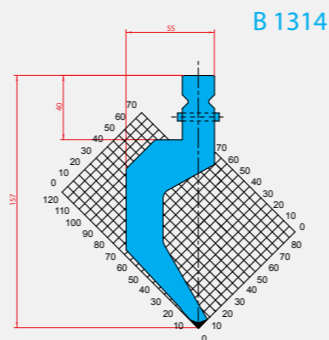
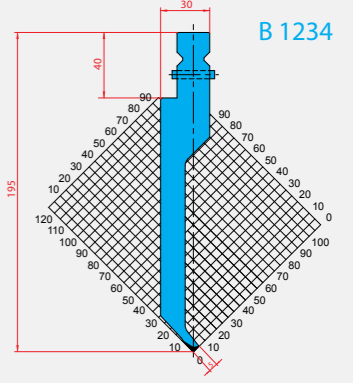
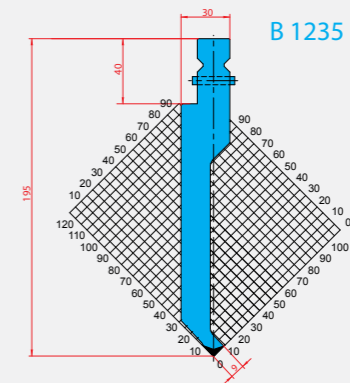
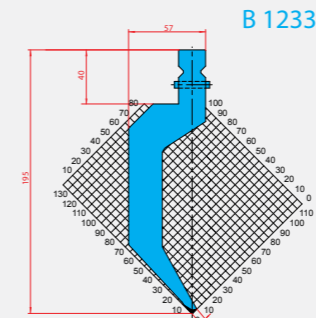
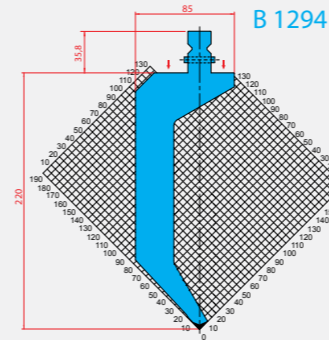
FOR PUNCHES:
1294 - 1303

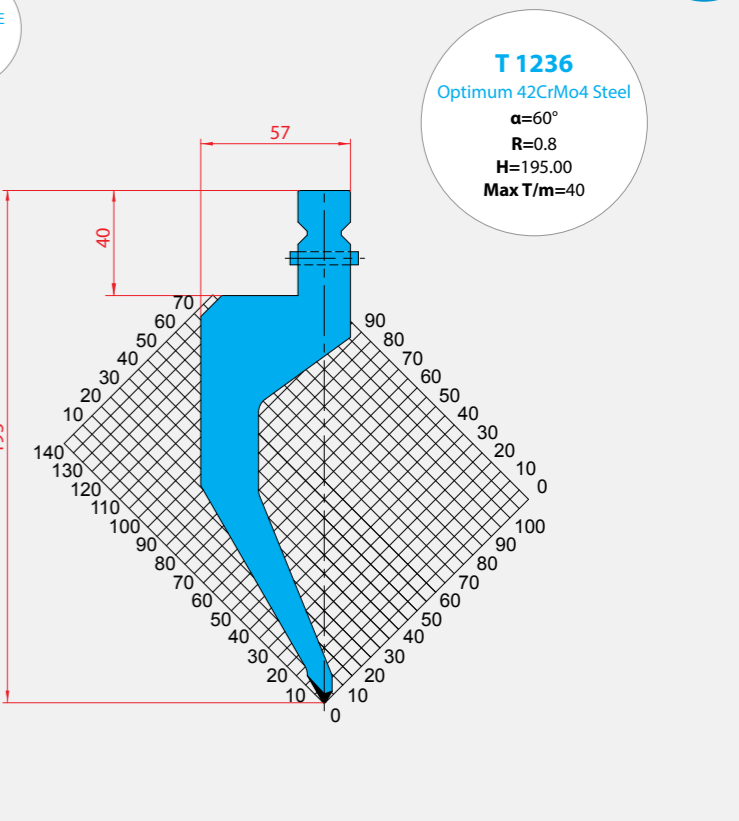
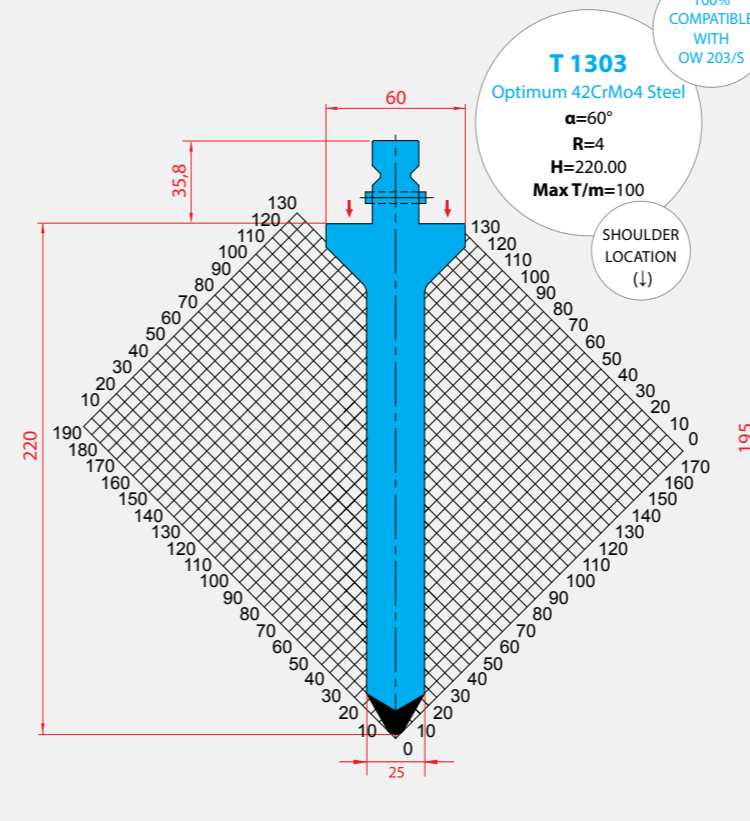
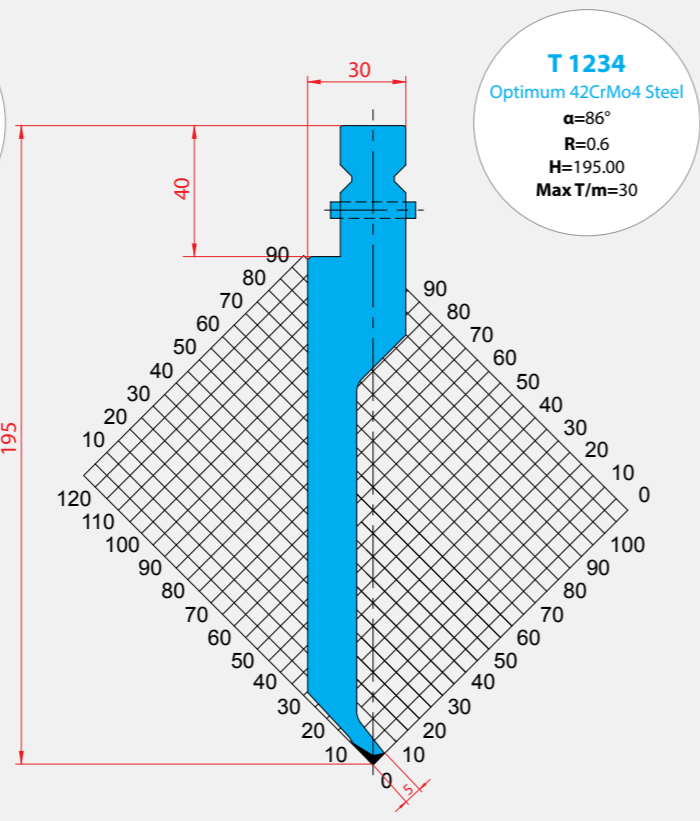
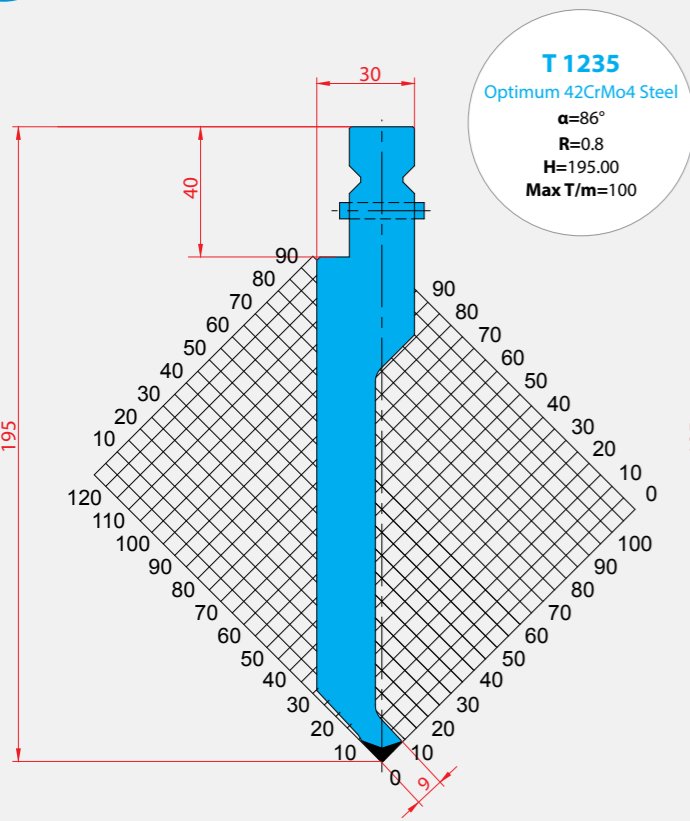
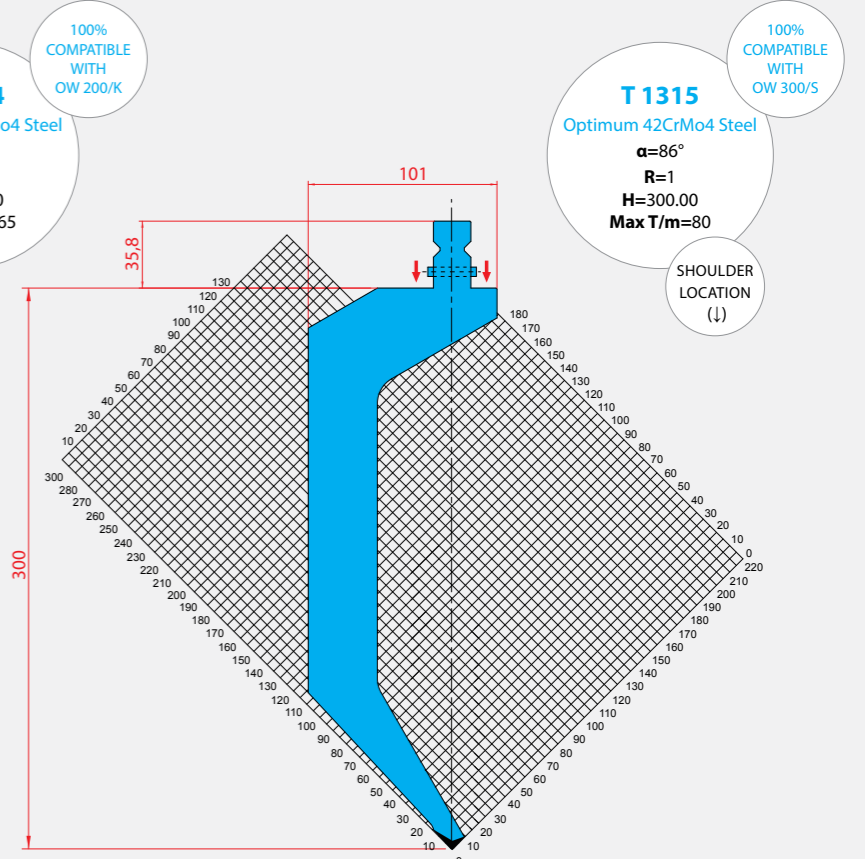
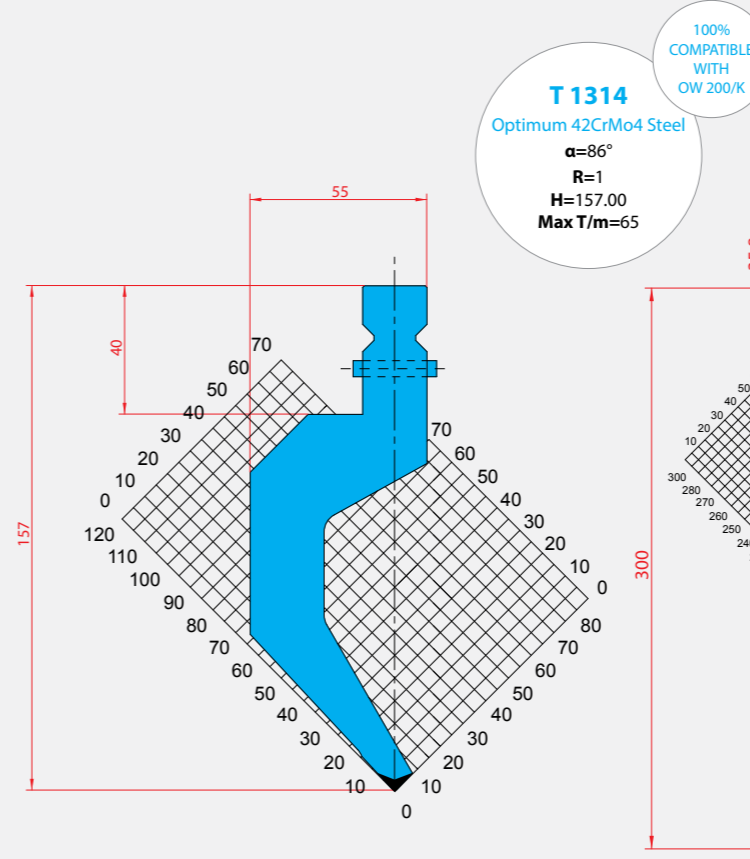
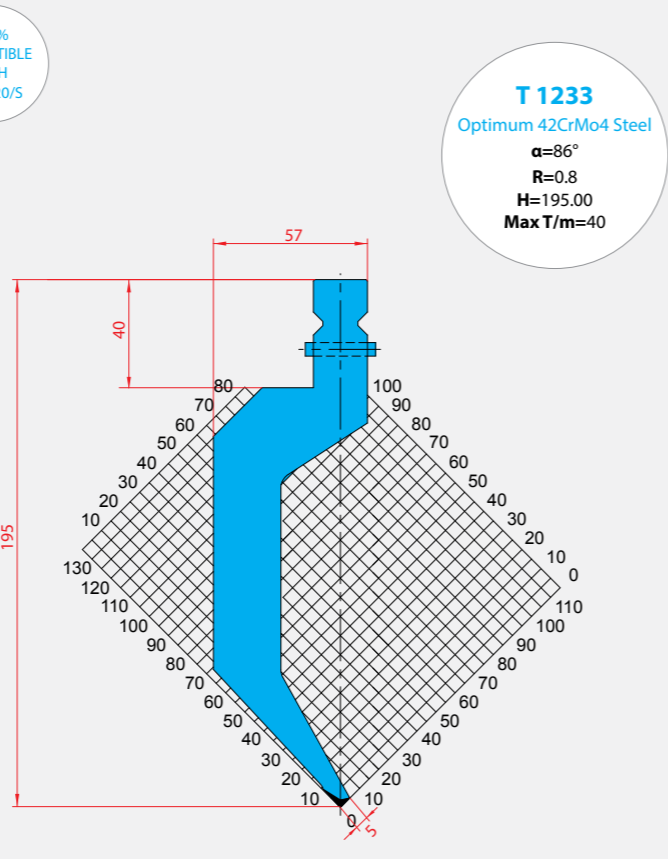
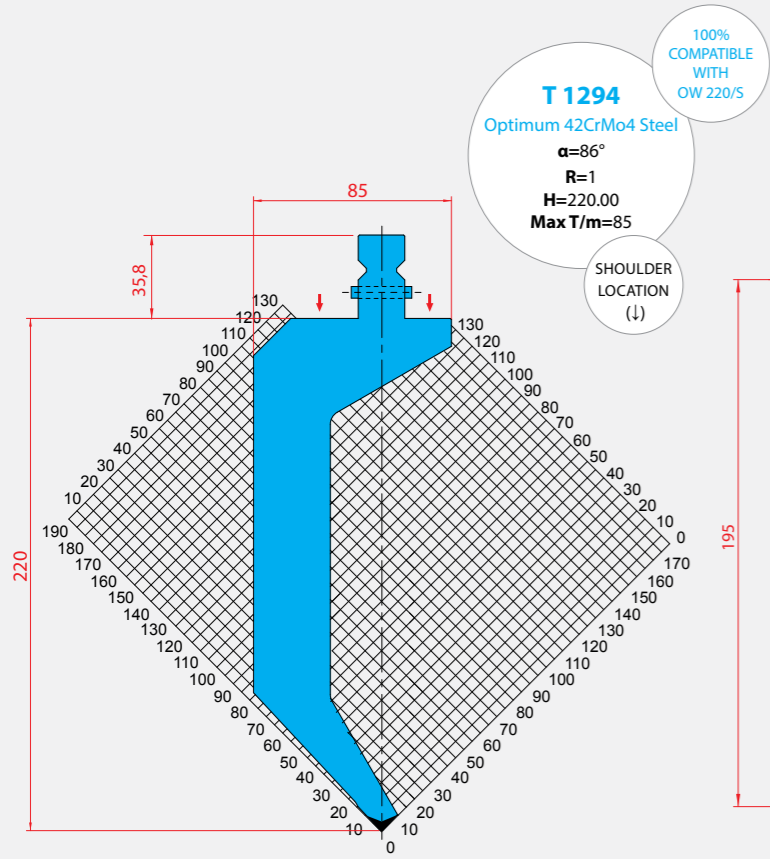
L	550	200	300
550	1	-	-
1050	1	1	1
1250	1	2	1
2050	1	3	3
2550	1	4	4
3050	1	5	5
4050	1	7	7

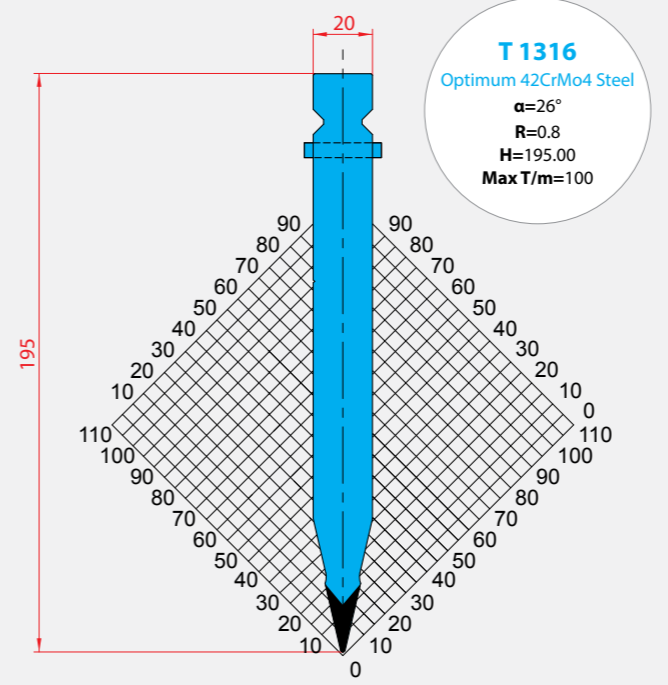
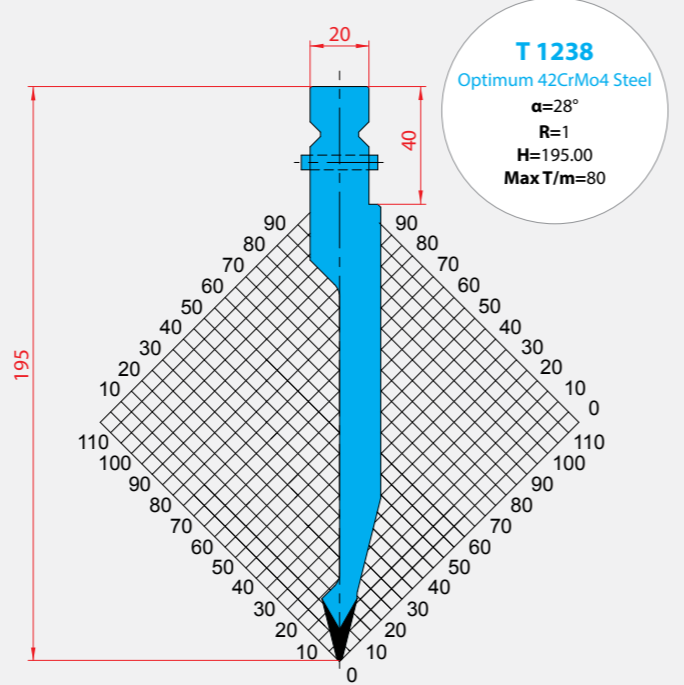
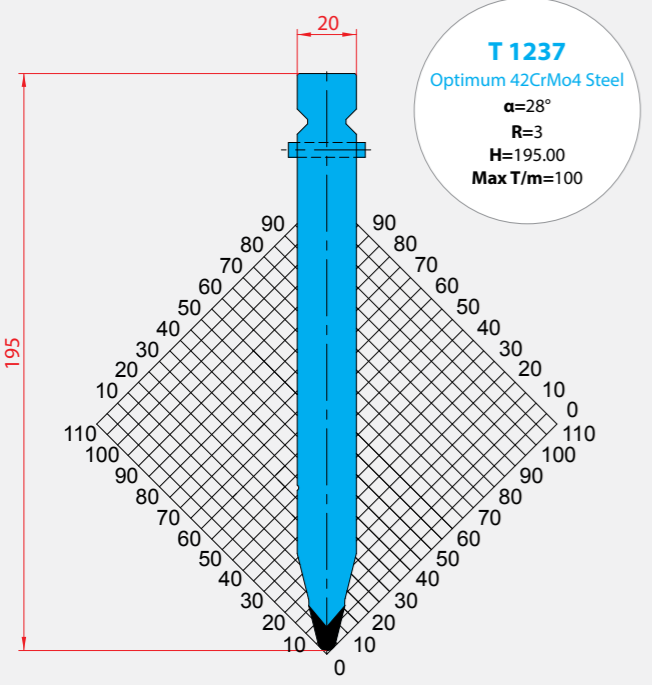
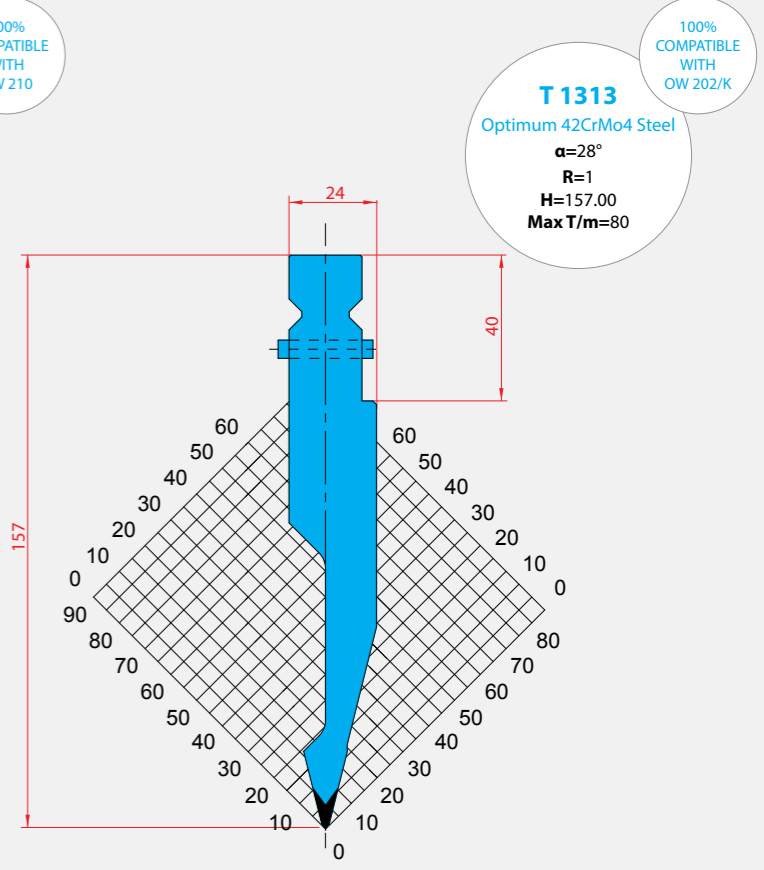
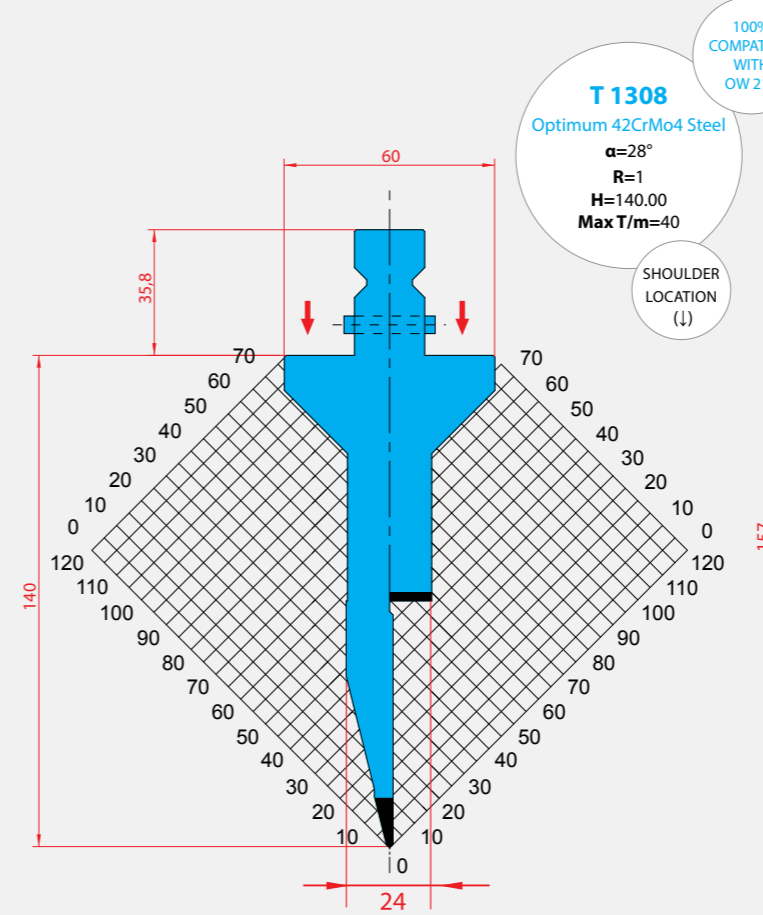
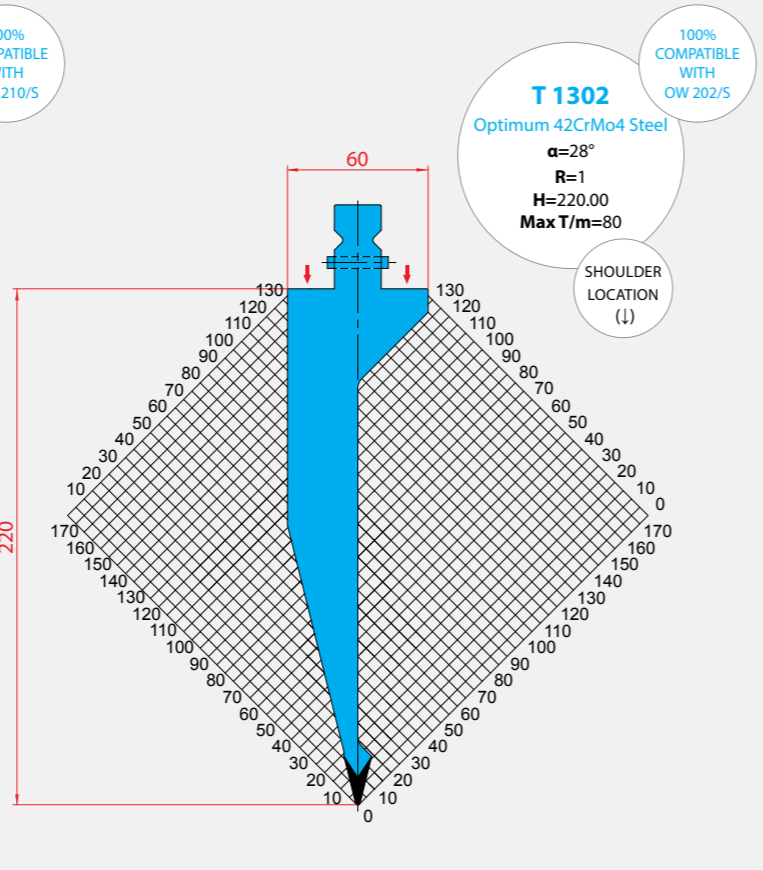
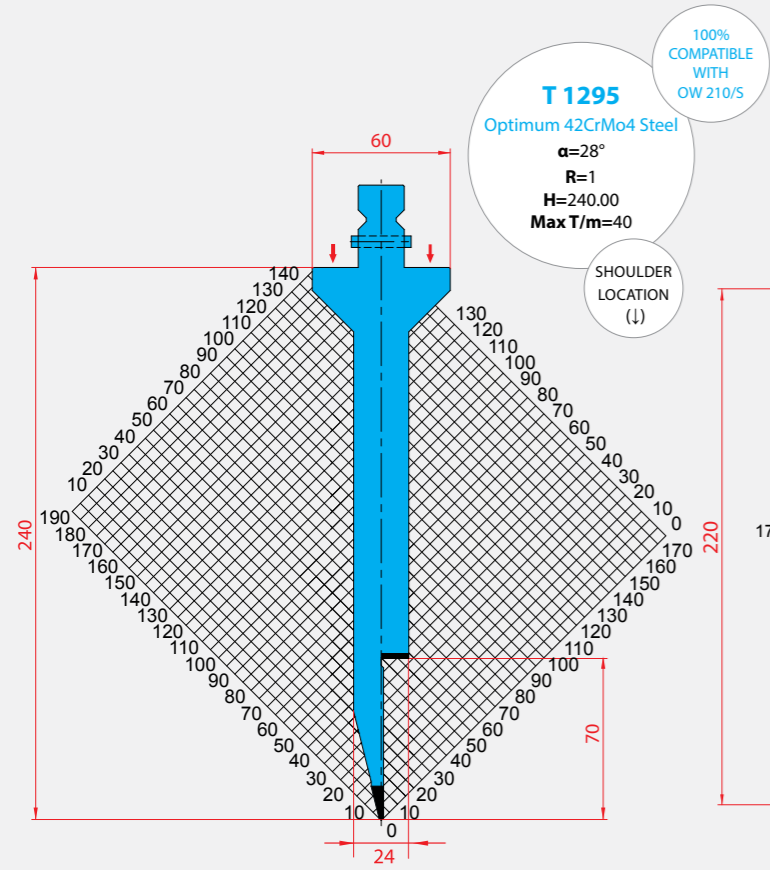
FOR PUNCHES:
1315

L	550	100	200
550	1	-	-
1050	1	1	2
1250	1	1	3
2050	1	1	7
2550	1	-	10
3050	1	1	12
4050	1	1	17

OVERVIEW







SAFETY
PUSH BUTTON
CLICK

DIES
TRUMPF RANGE

T 8210
MILLING FOR SAFETY
PUSH BUTTON

T 8211
code
-1237 -1240

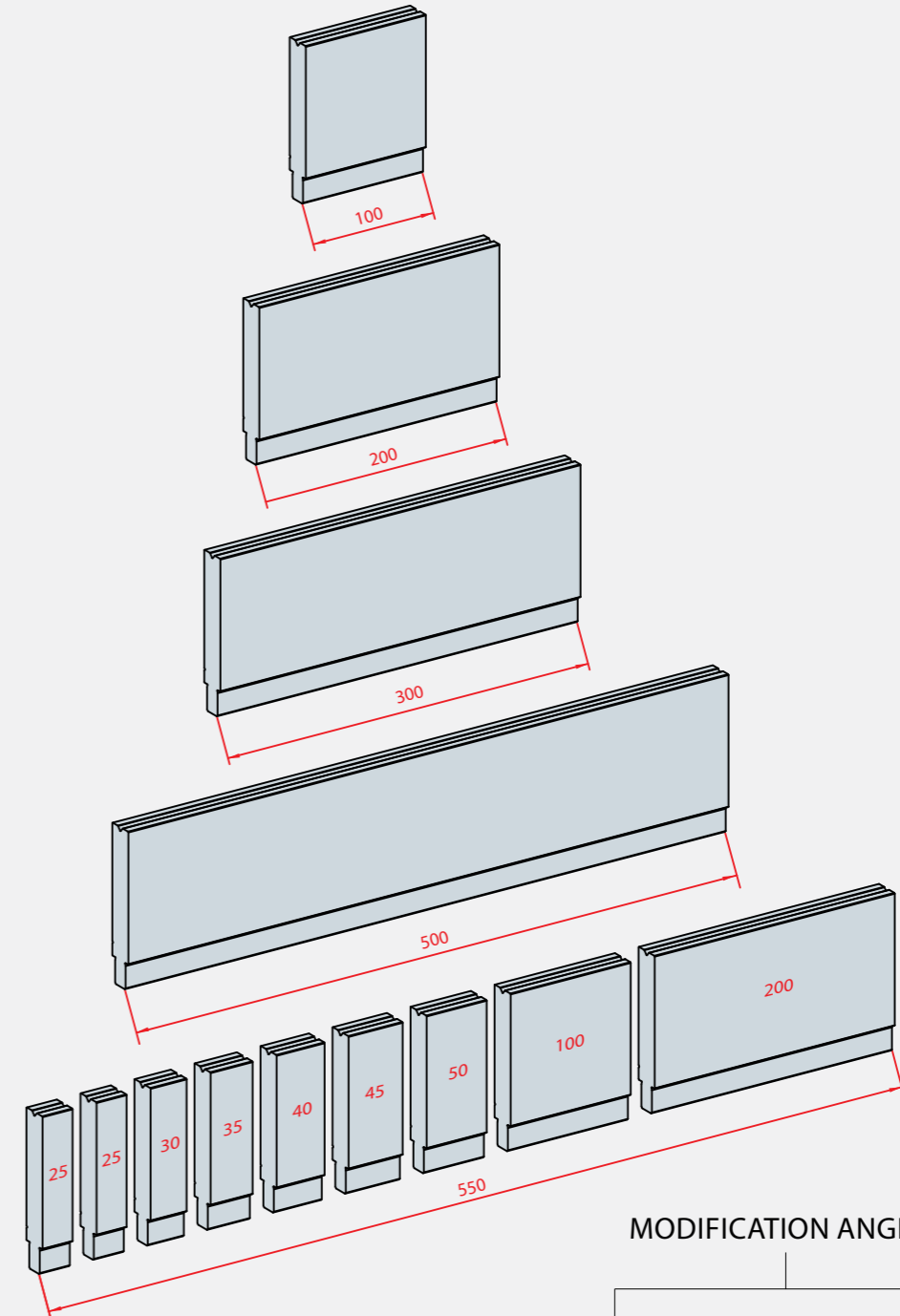
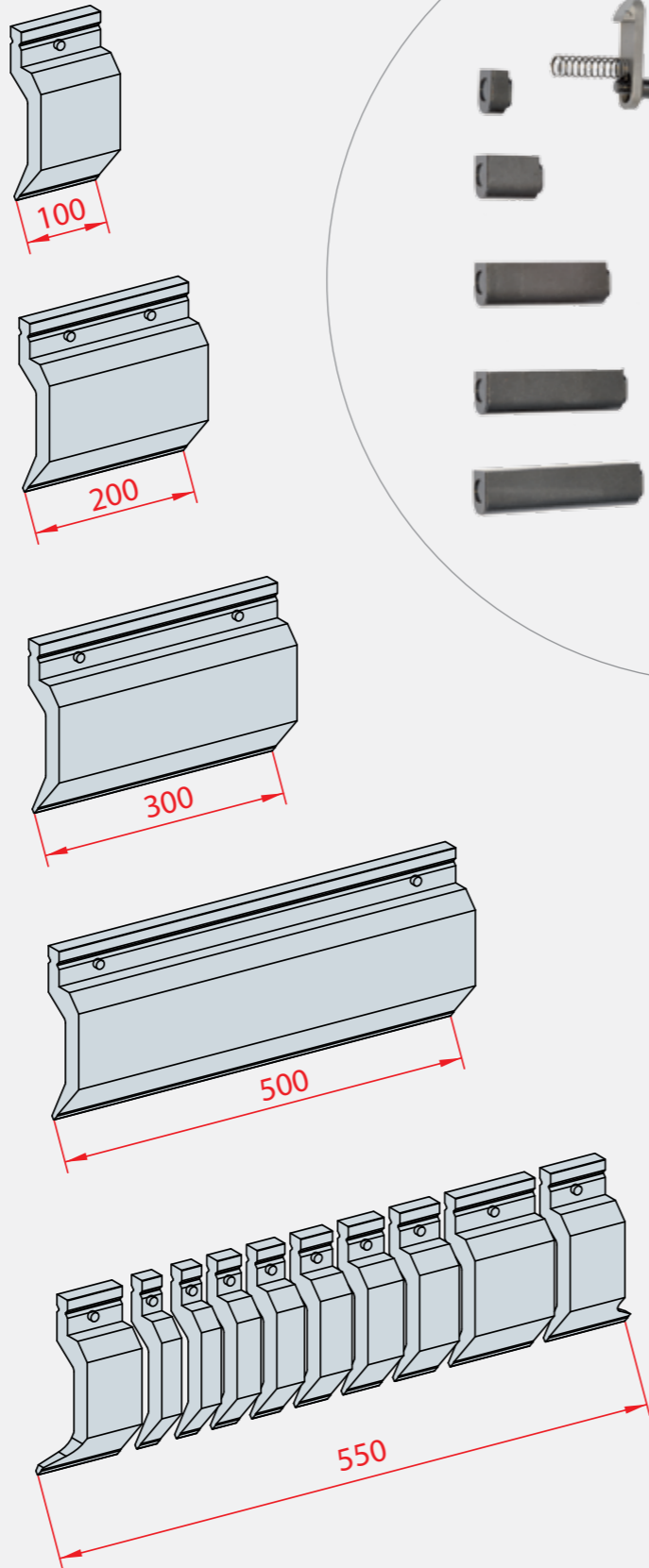
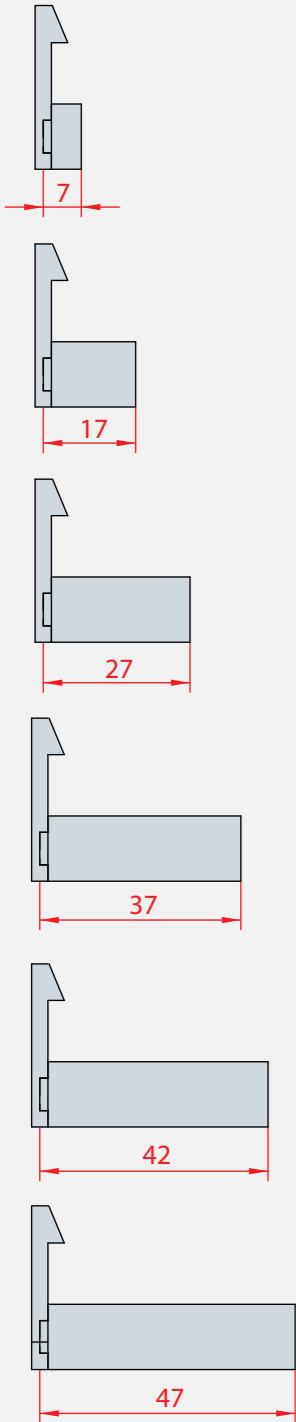
T 8212
code
-1234 -1235 -1238
-1249 -1250 -1251
-1313

T 8213
code
-1295 -1302
-1303 -1308

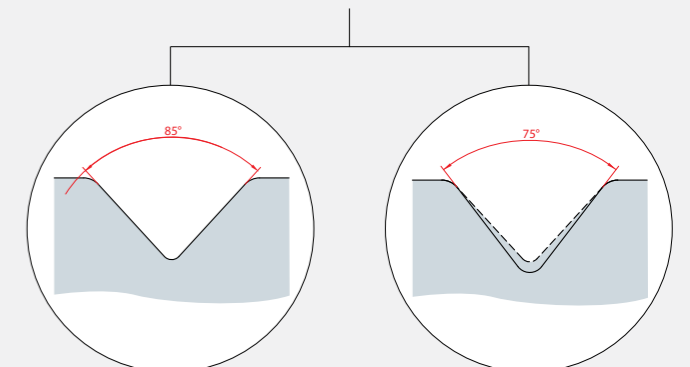
T 8214
code
-1233 -1314

T 8215
code
-1236

T 8216
code
-1294



MODIFICATION ANGLES



FOR DIES:
3135 - 3222
3223 - 3224

L	550	100	200
550	1	-	-
1050	1	1	2
1250	1	3	2
2050	1	5	5
2550	1	6	7
3050	1	7	9
4050	1	9	13

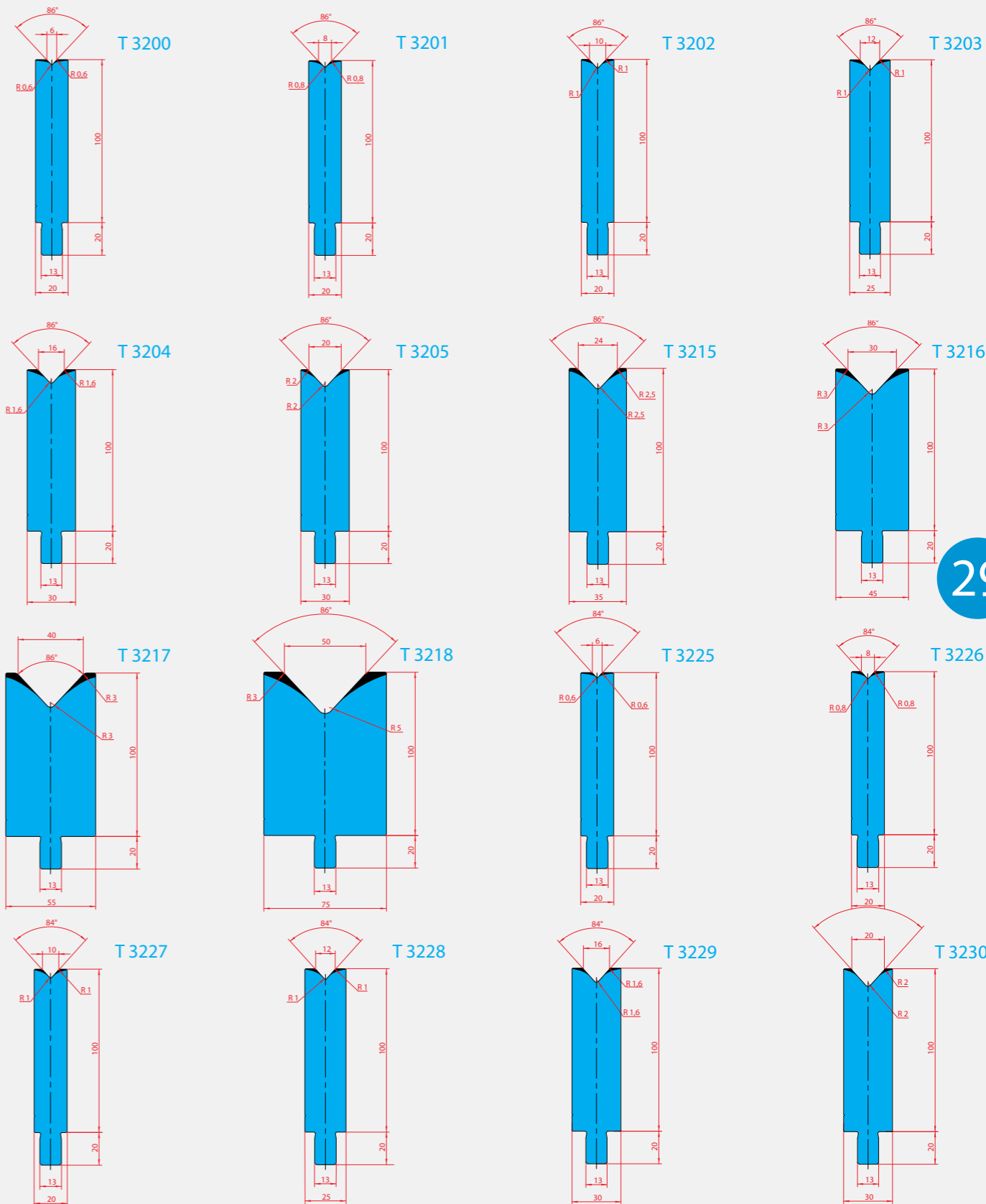
FOR DIES:
3218 - 3219 - 3220
3221 - 3132 - 3133
3144

L	550	100	200	300
550	1	-	-	-
1050	1	2	-	1
1250	1	2	1	1
2050	1	2	2	3
2550	1	2	3	4
3050	1	2	4	5
4050	1	2	6	7

**FOR ALL OTHER
TYPE OF DIES**

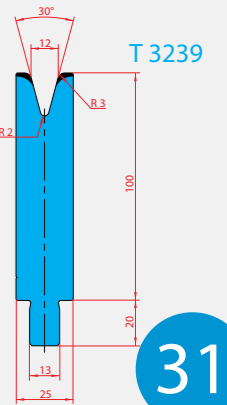
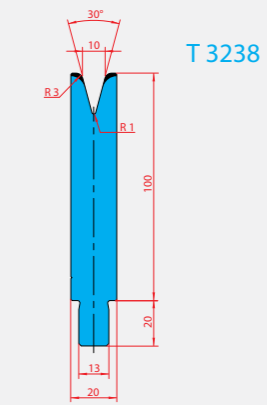
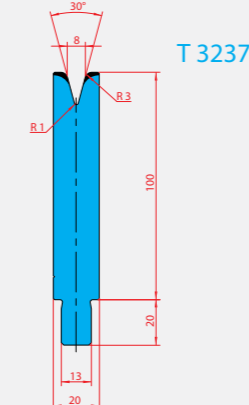
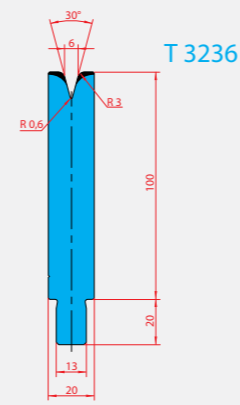
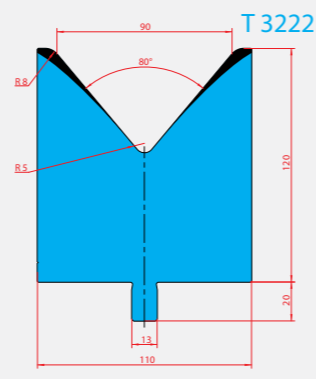
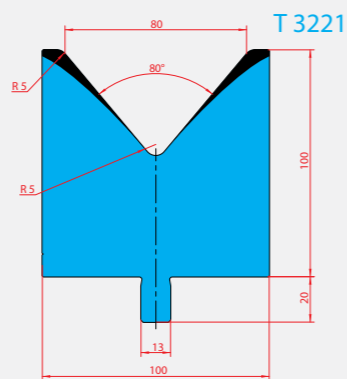
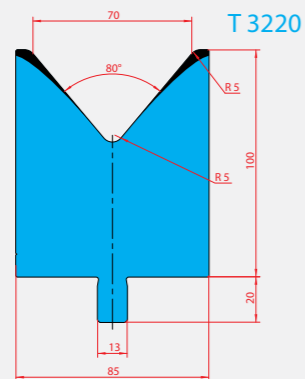
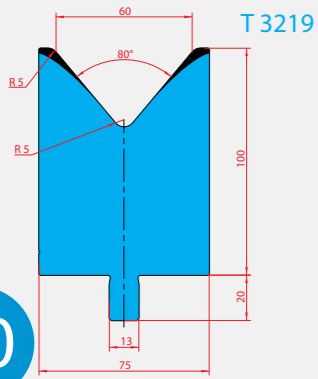
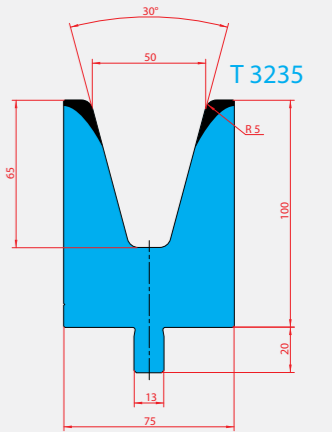
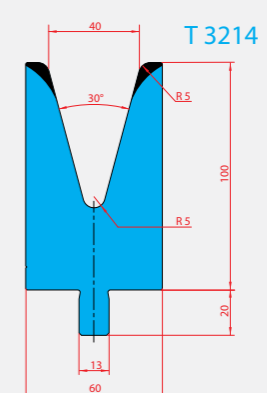
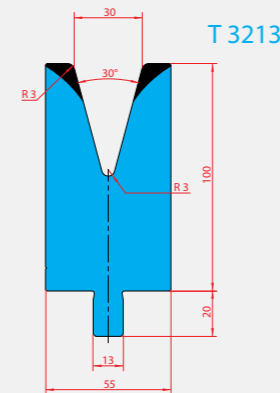
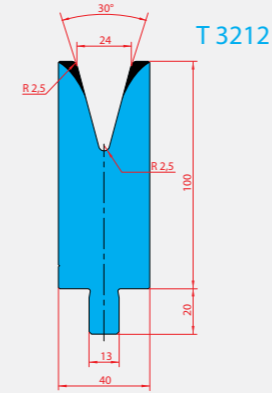
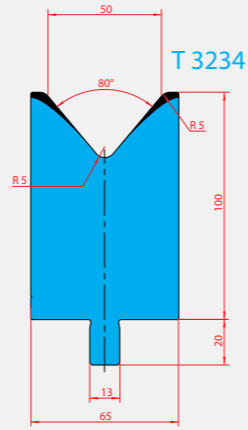
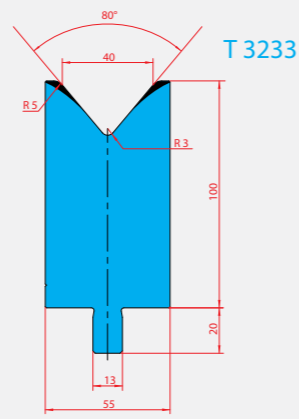
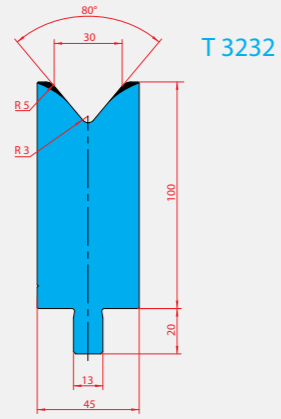
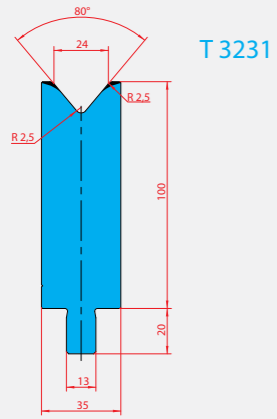
L	550	100	200	300	500
550	1	-	-	-	-
1050	1	2	1	1	-
1250	1	2	-	1	-
2050	1	2	-	1	2
2550	1	2	-	1	3
3050	1	2	-	1	4
4050	1	2	-	1	6

OVERVIEW



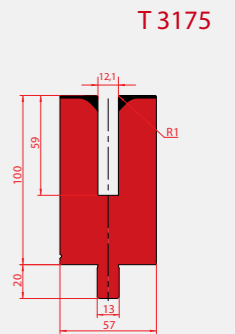
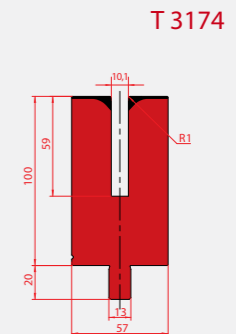
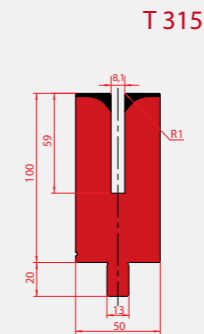
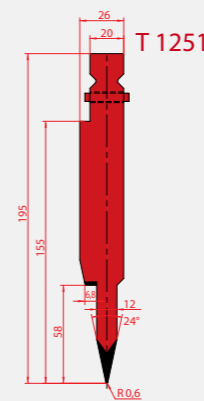
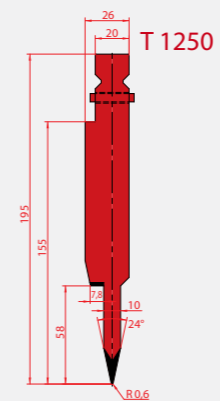
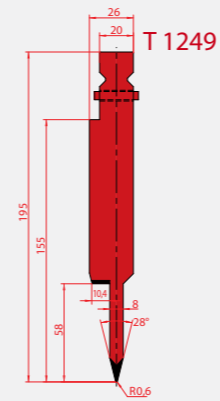
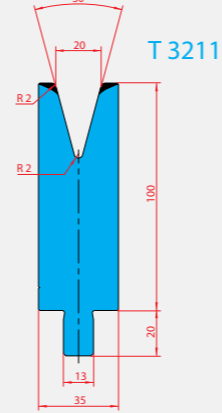
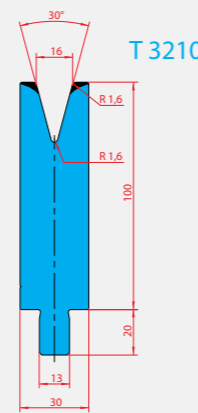
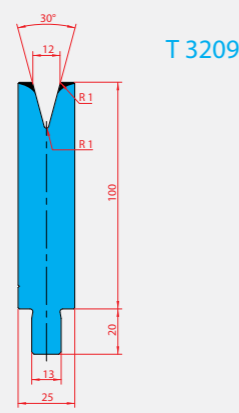
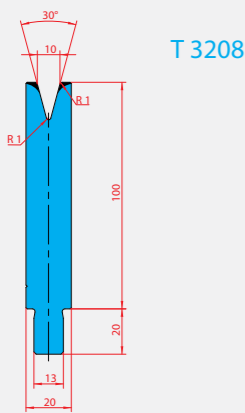
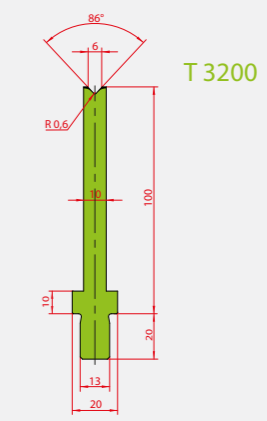
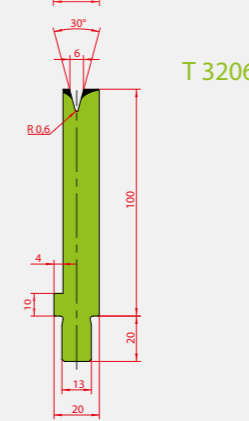
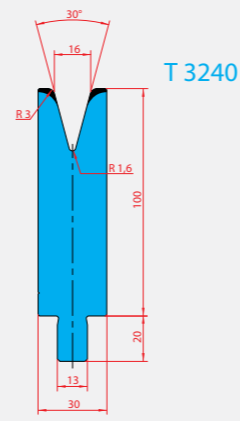
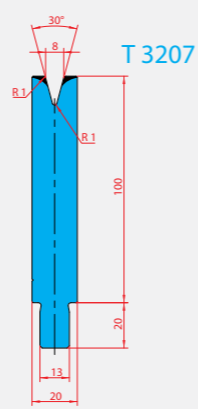
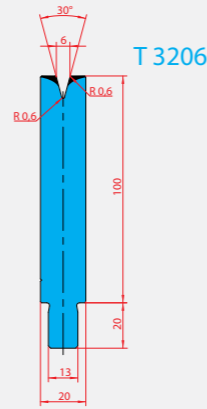
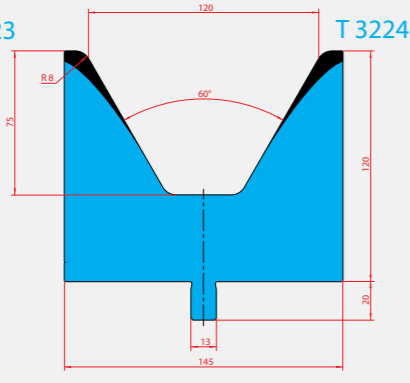
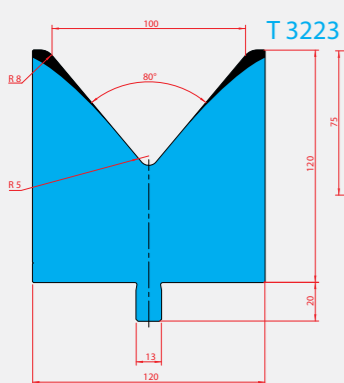
OVERVIEW

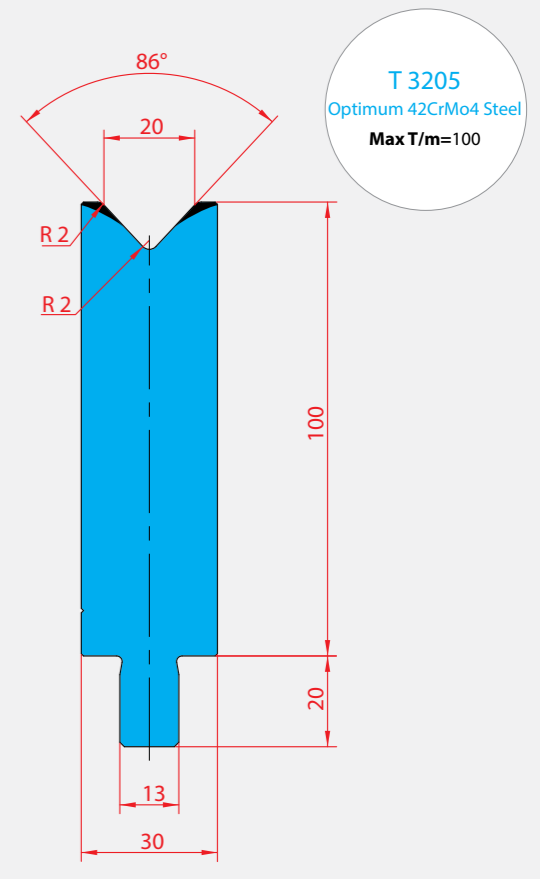
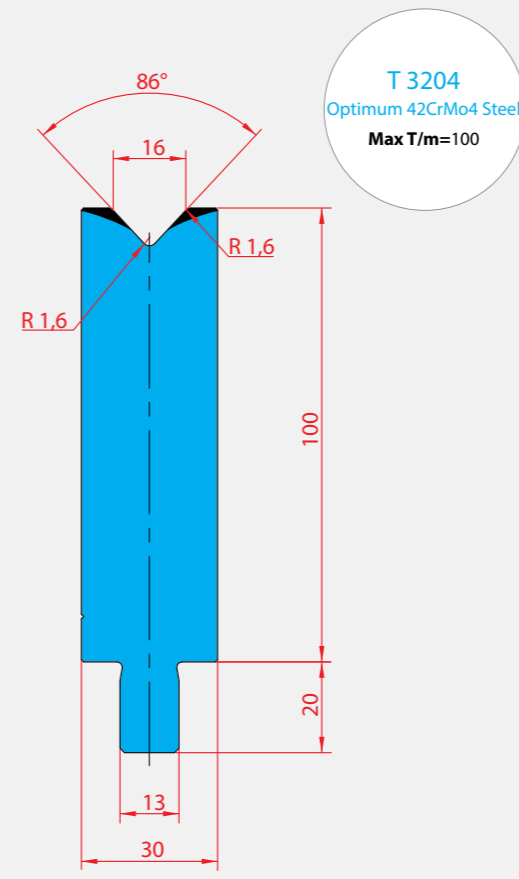
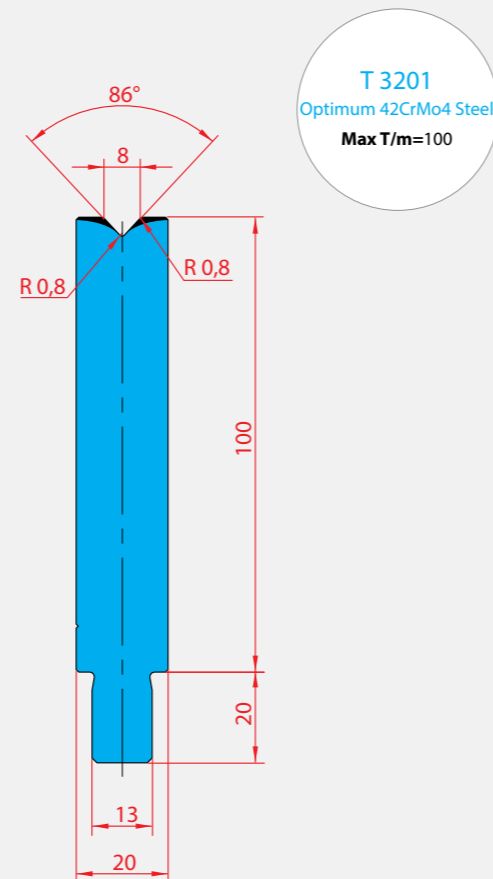
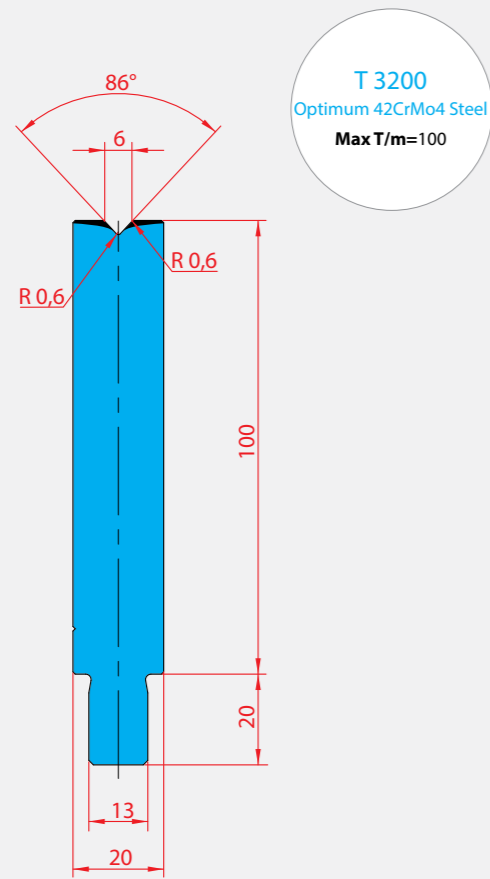
OVERVIEW



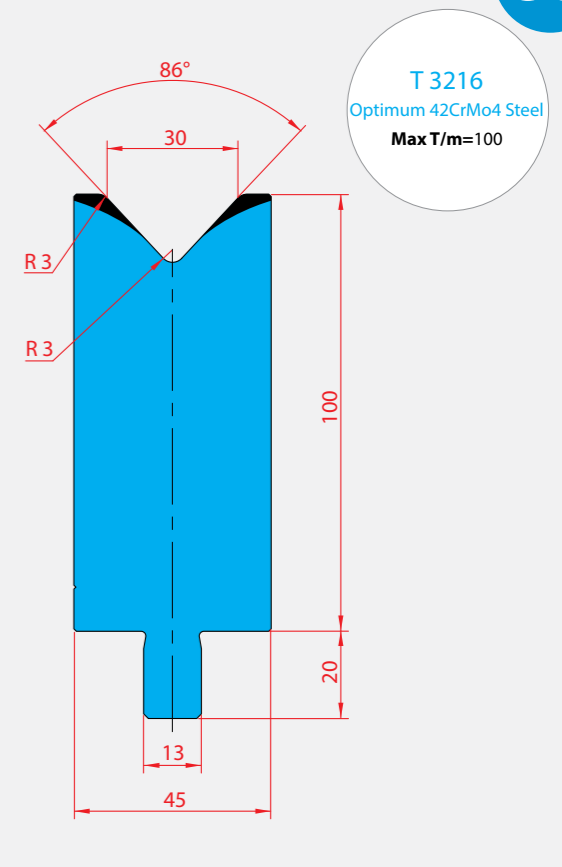
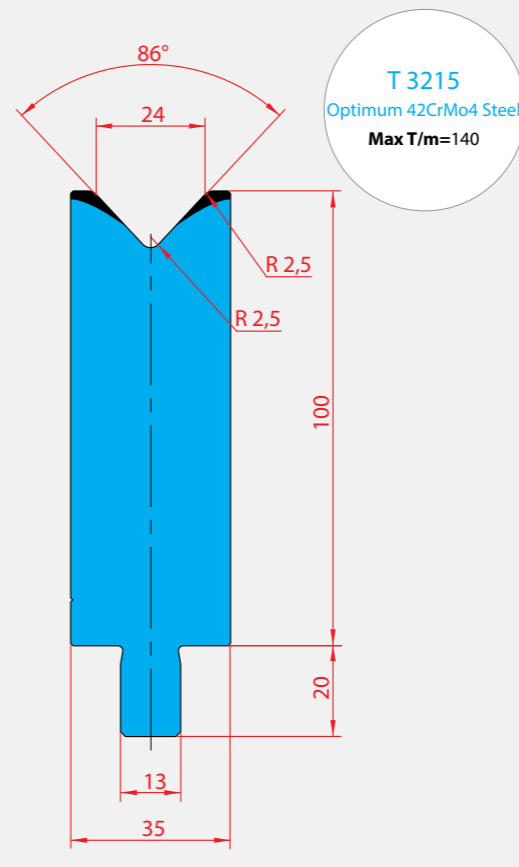
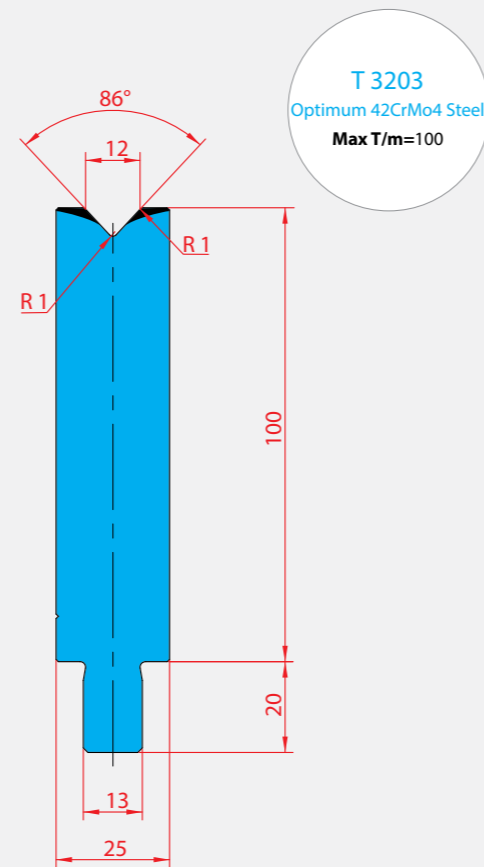
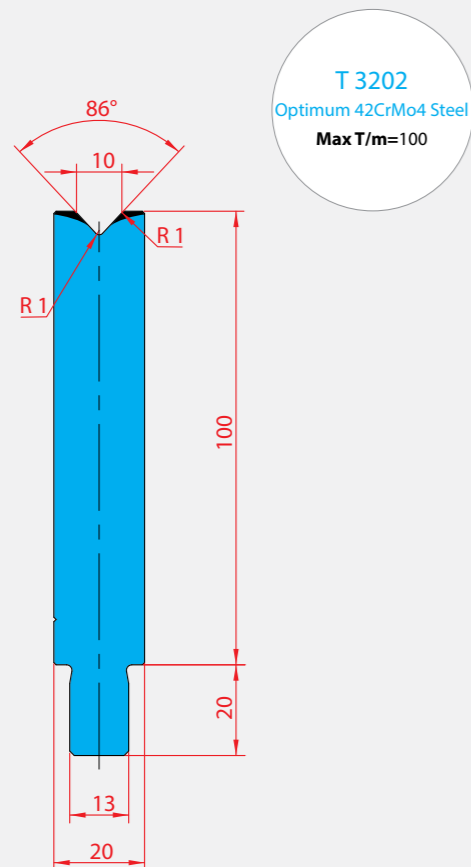
30

31



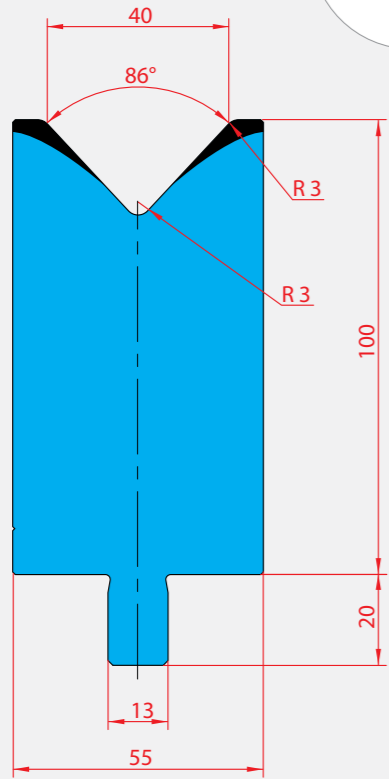


32

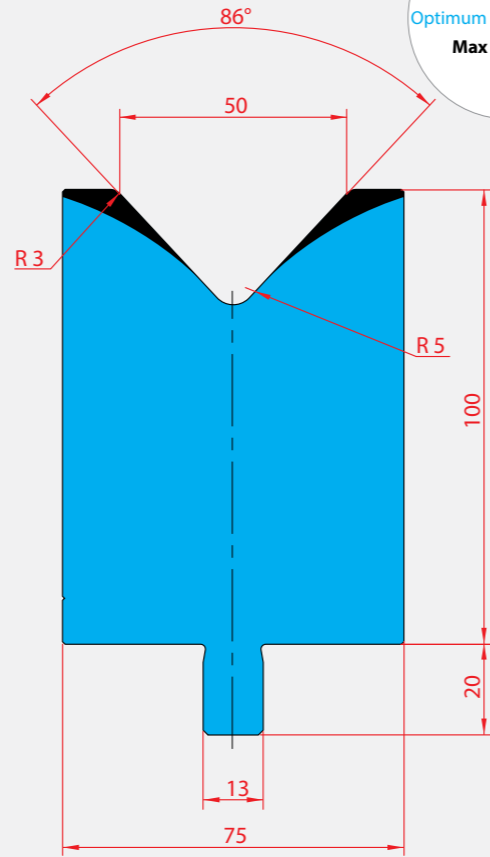


33

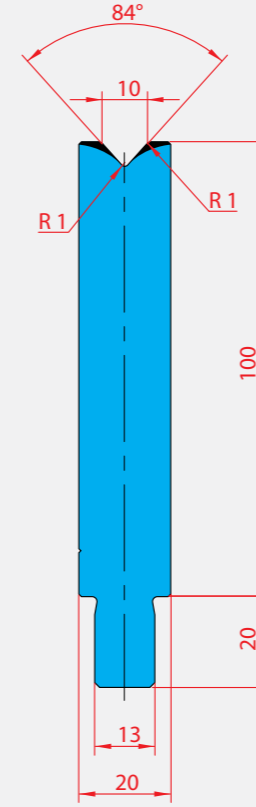
T 3217
Optimum 42CrMo4 Steel
Max T/m=120



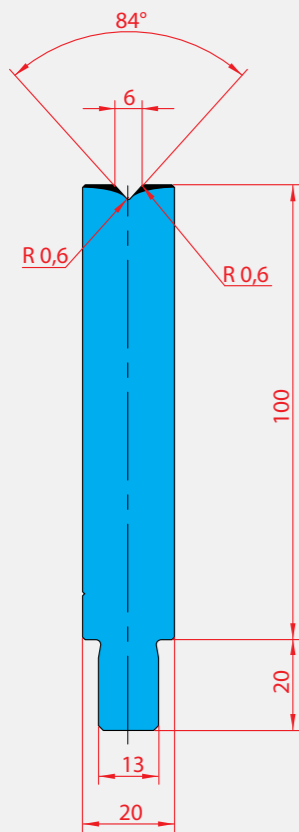
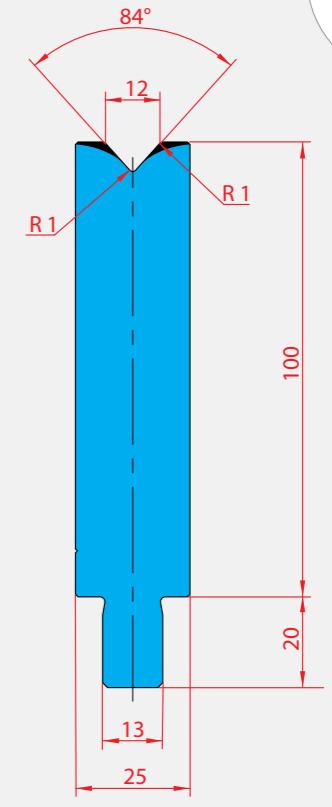
T 3218
Optimum 42CrMo4 Steel
Max T/m=150



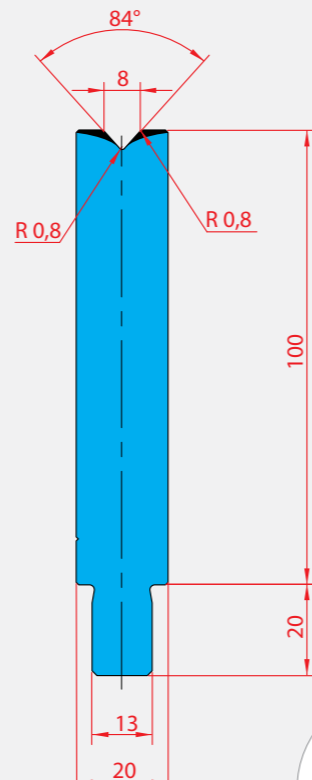
T 3227
Optimum 42CrMo4 Steel
Max T/m=100
EV W10/84°



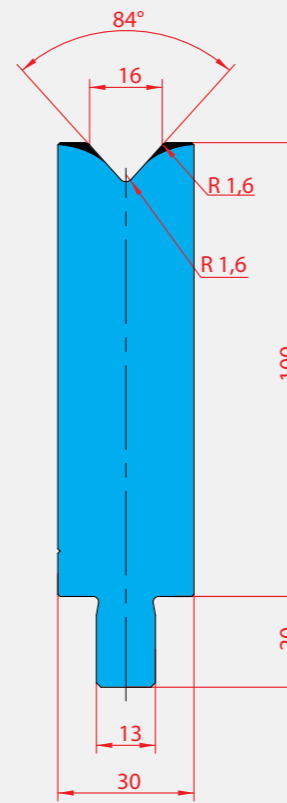
T 3228
Optimum 42CrMo4 Steel
Max T/m=100
EV W8/84°



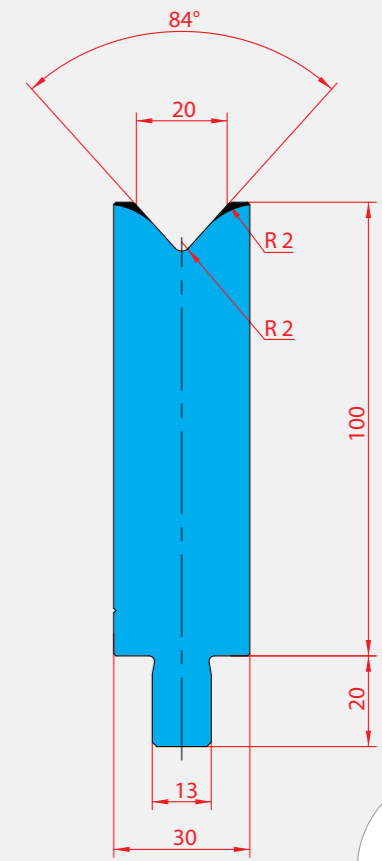
T 3225
Optimum 42CrMo4 Steel
Max T/m=130
EV W6/84°



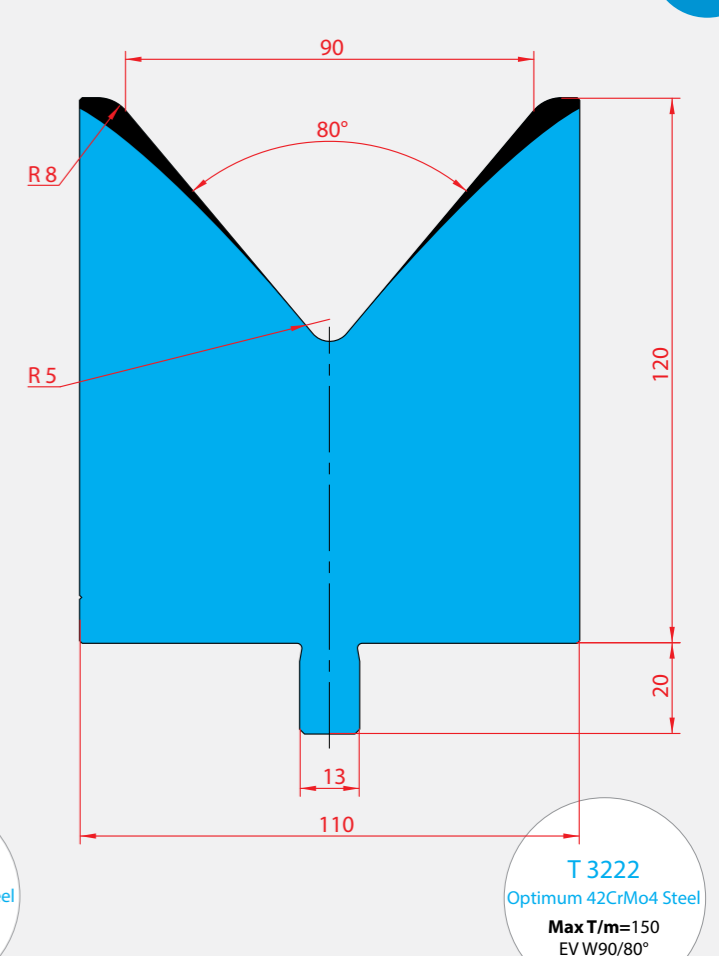
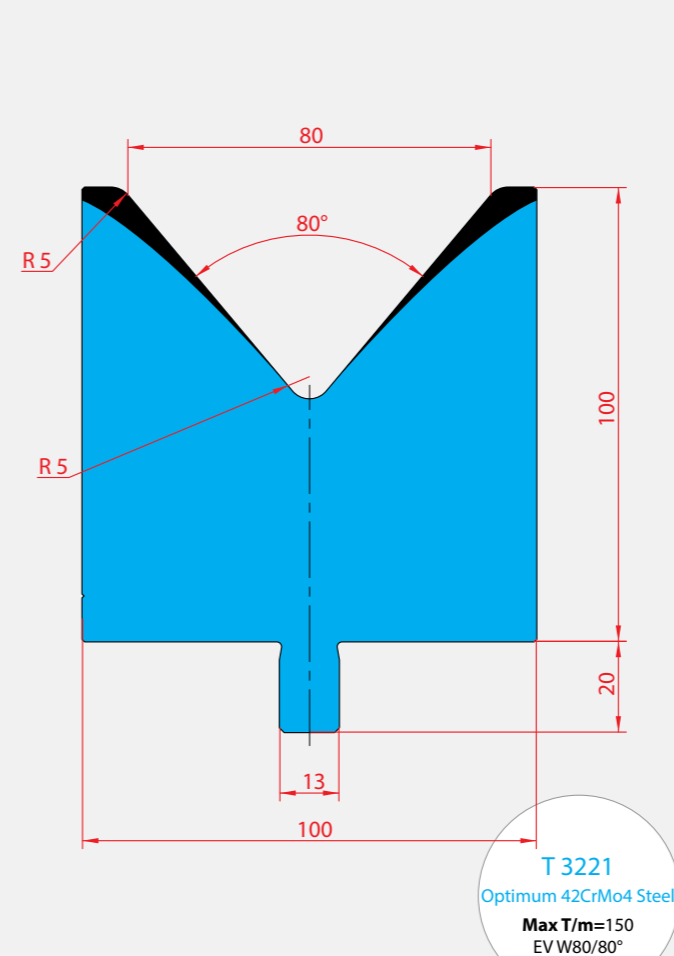
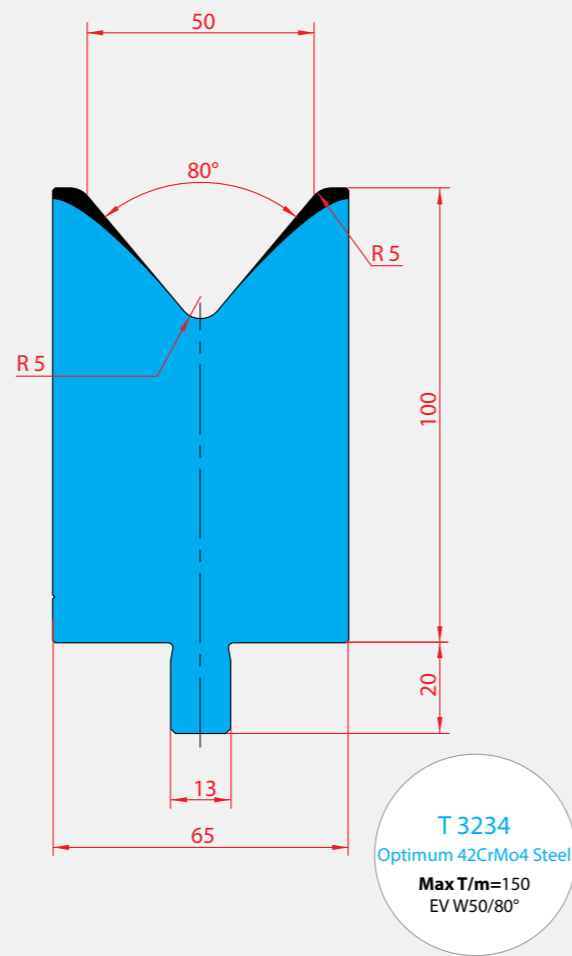
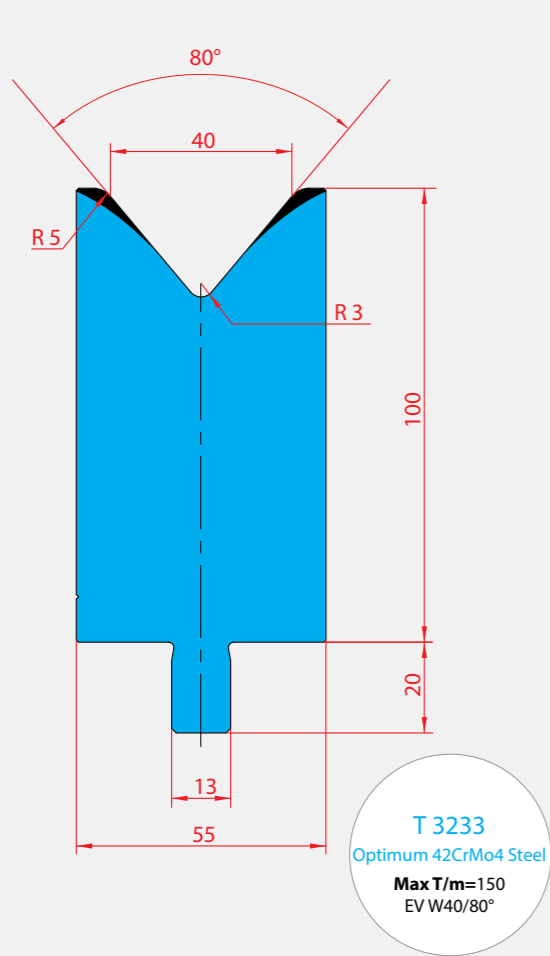
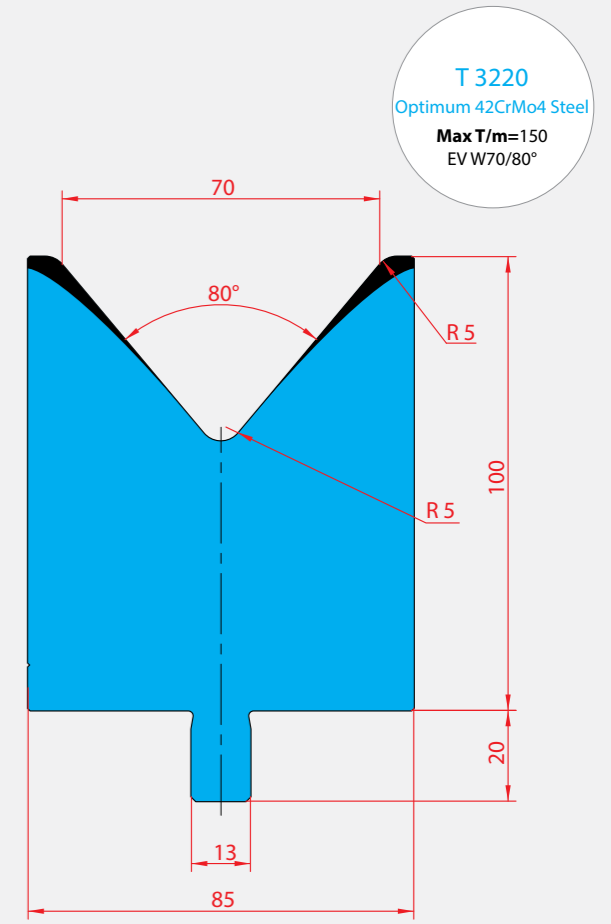
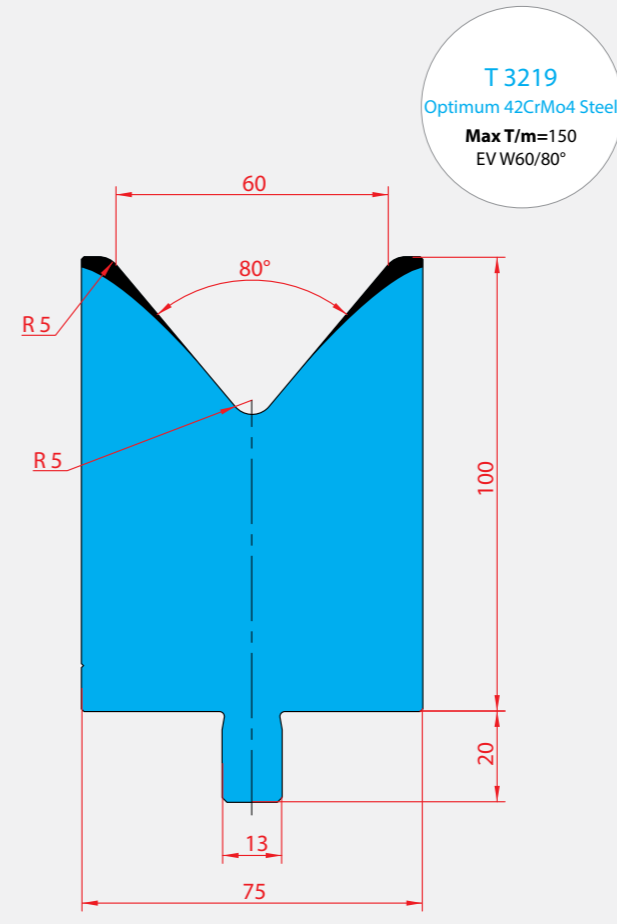
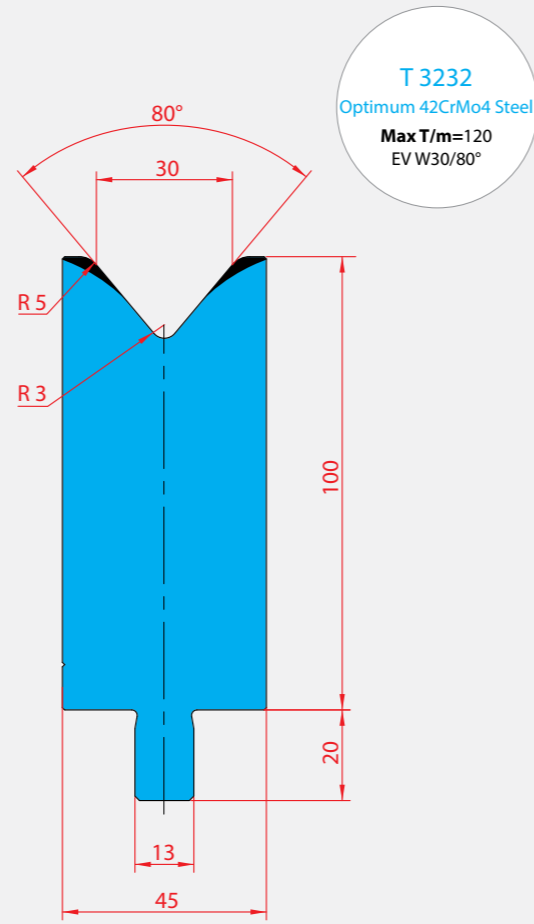
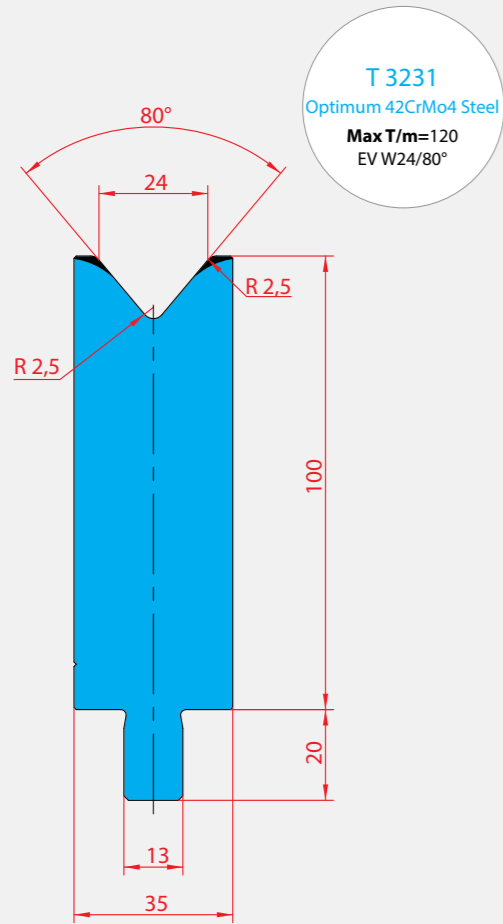
T 3226
Optimum 42CrMo4 Steel
Max T/m=100
EV W8/84°

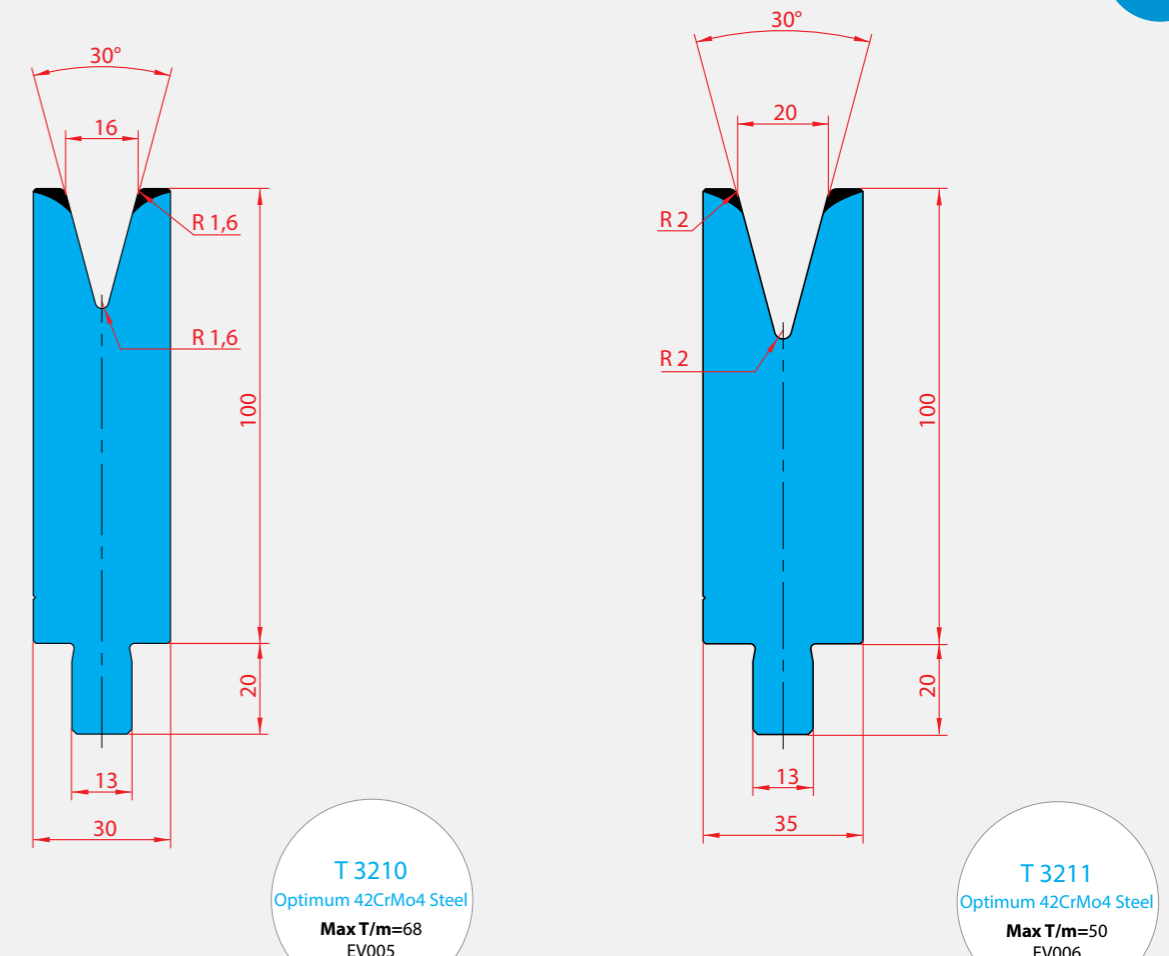
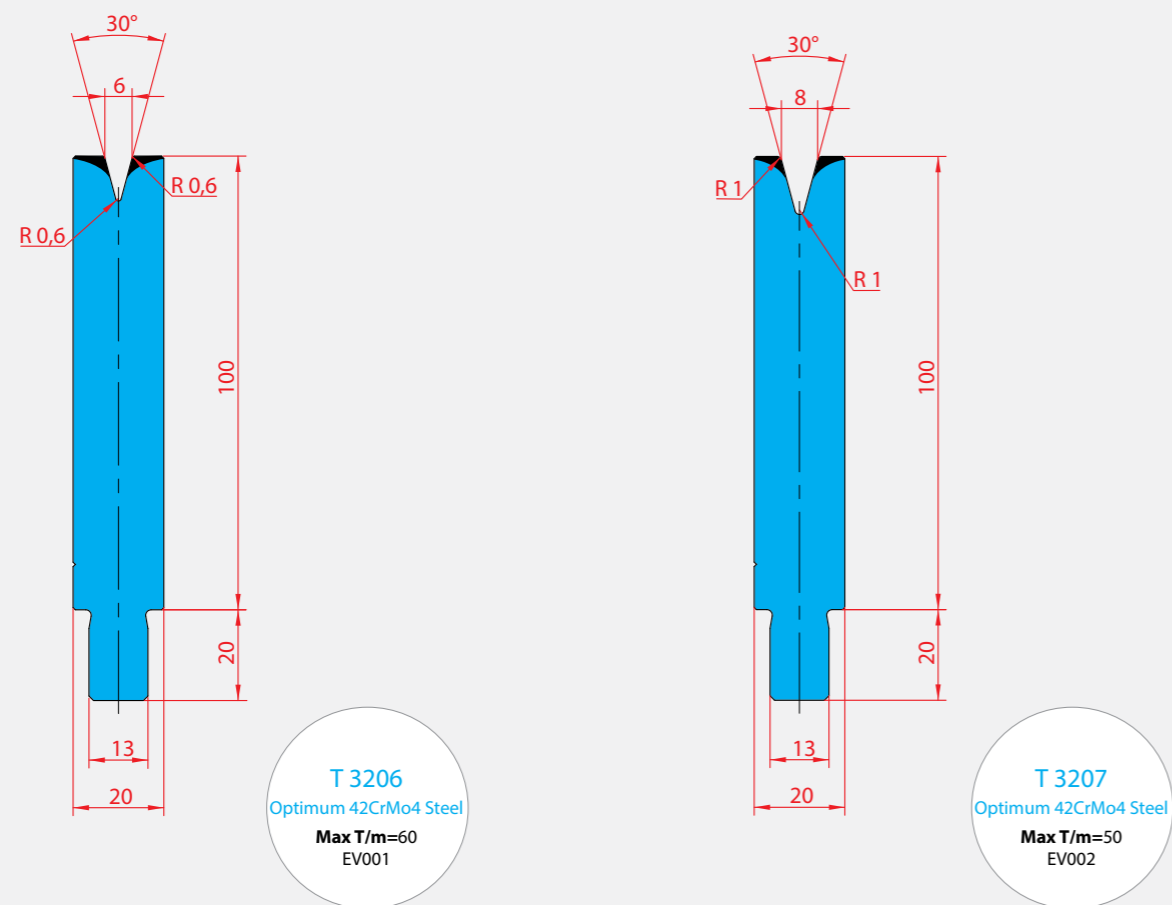
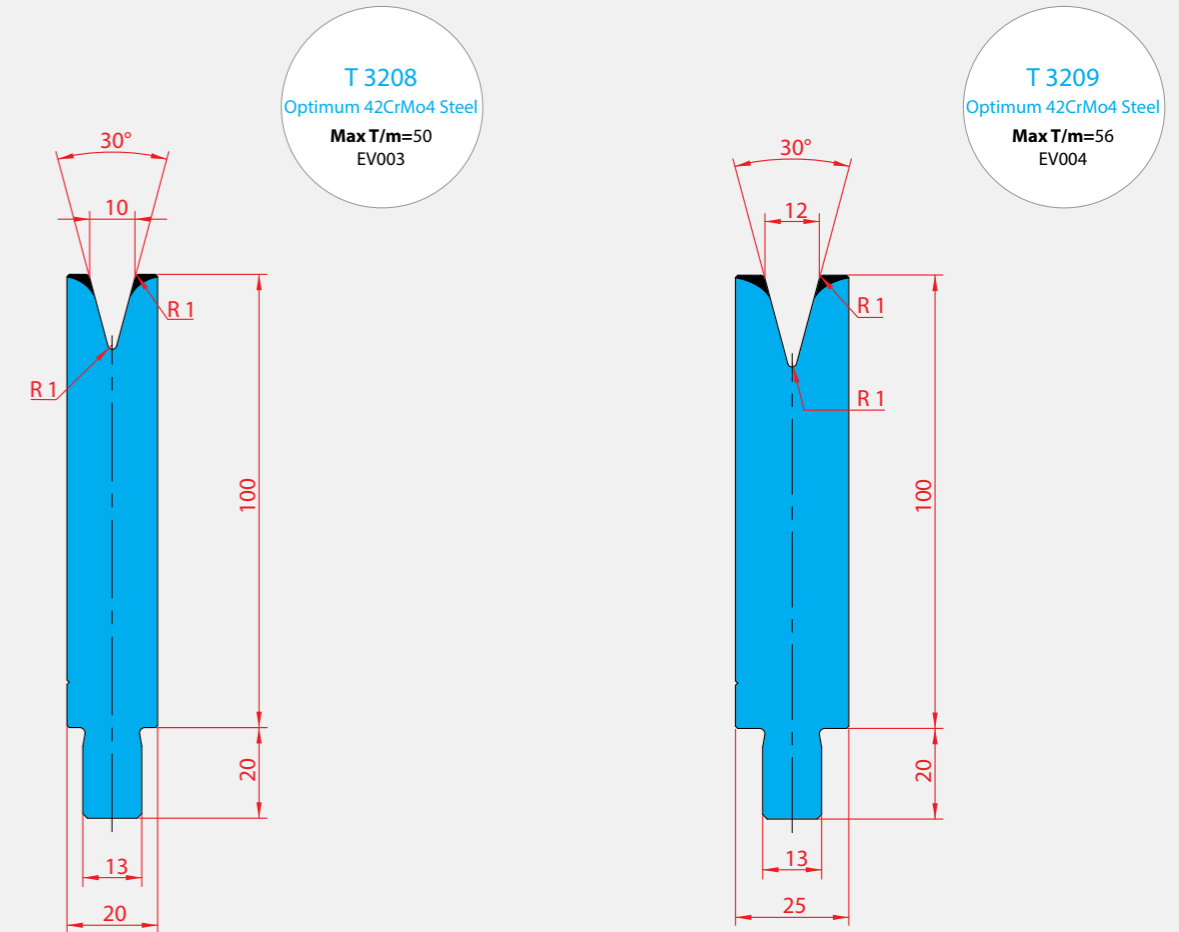
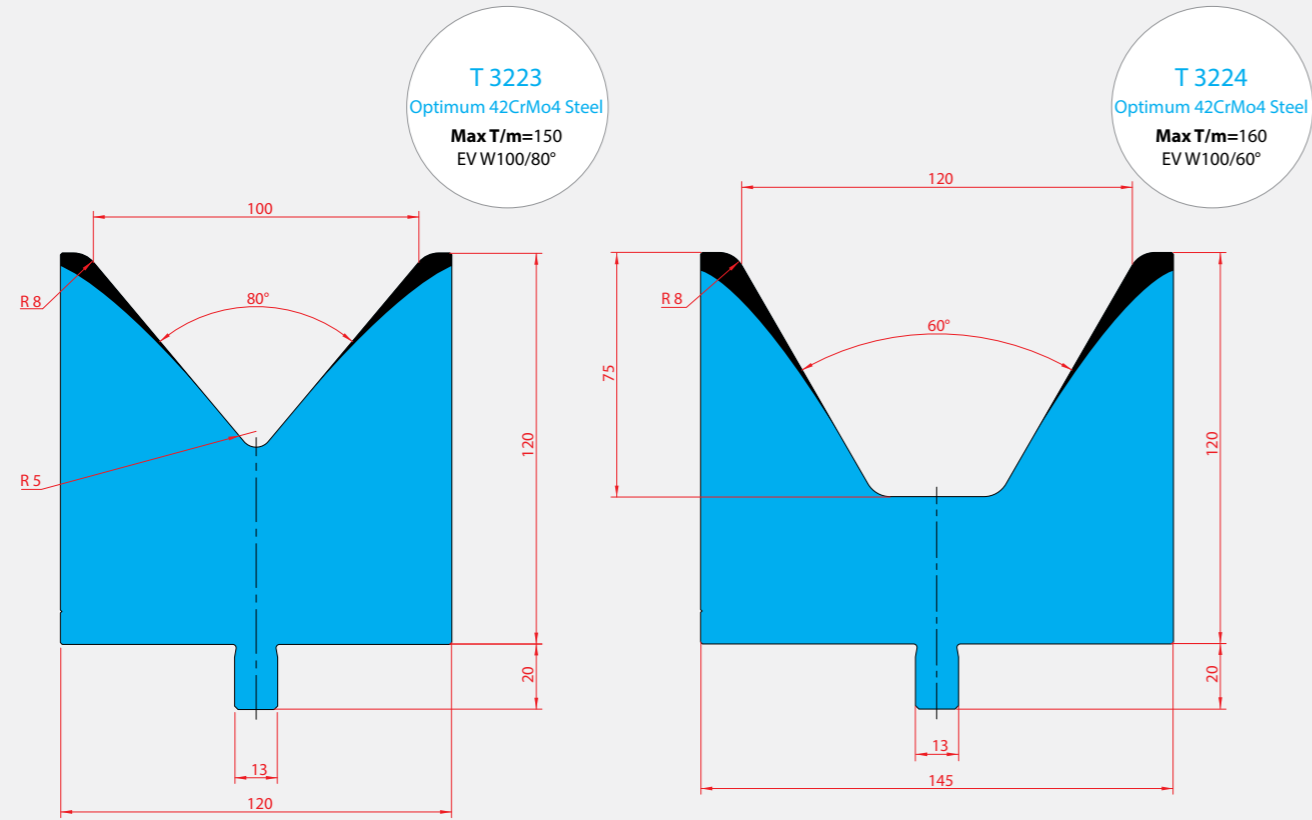


T 3229
Optimum 42CrMo4 Steel
Max T/m=100
EV W16/84°

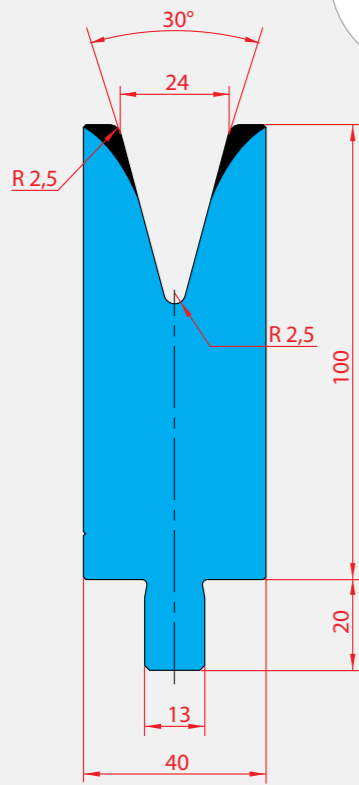


T 3230
Optimum 42CrMo4 Steel
Max T/m=100
EV W20/84°

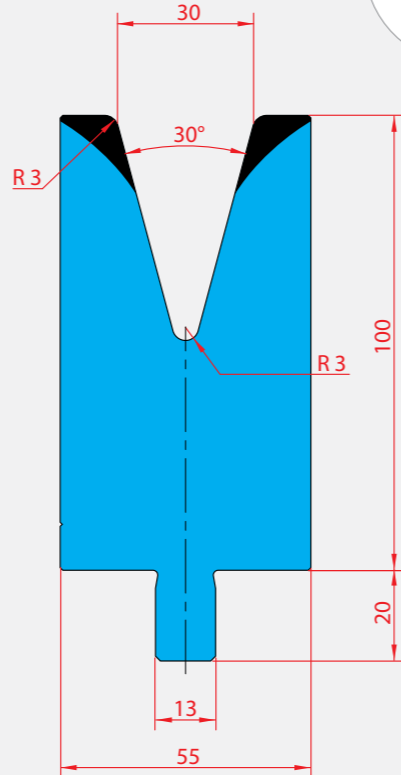




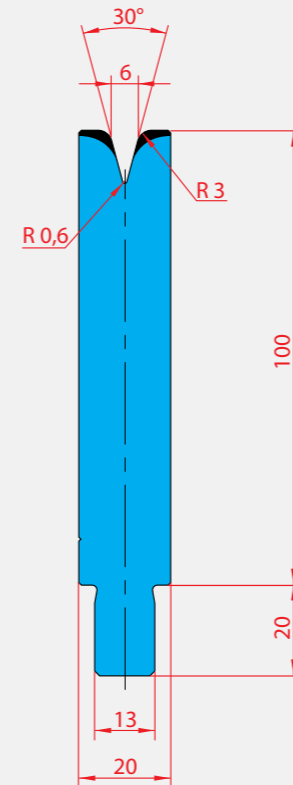
T 3212
Optimum 42CrMo4 Steel
Max T/m=55
EV007



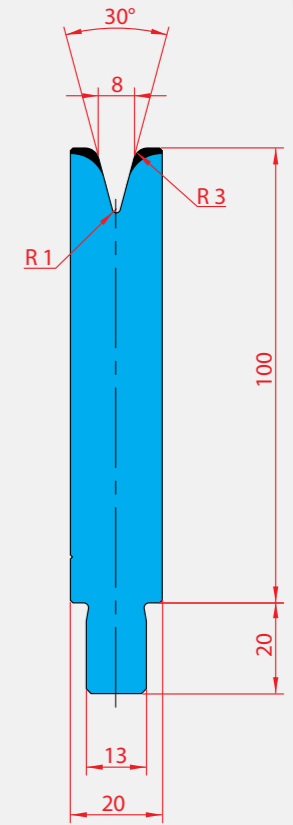
T 3213
Optimum 42CrMo4 Steel
Max T/m=85
EV W30/30°



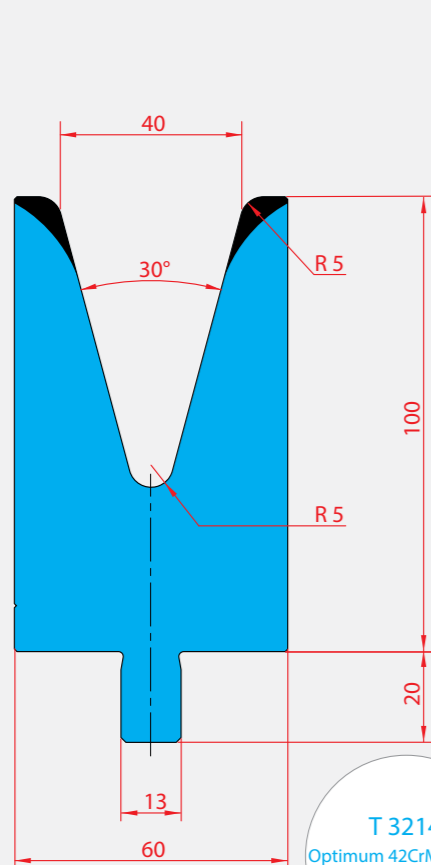
T 3236
Optimum 42CrMo4 Steel
Max T/m=45
EV001 R3



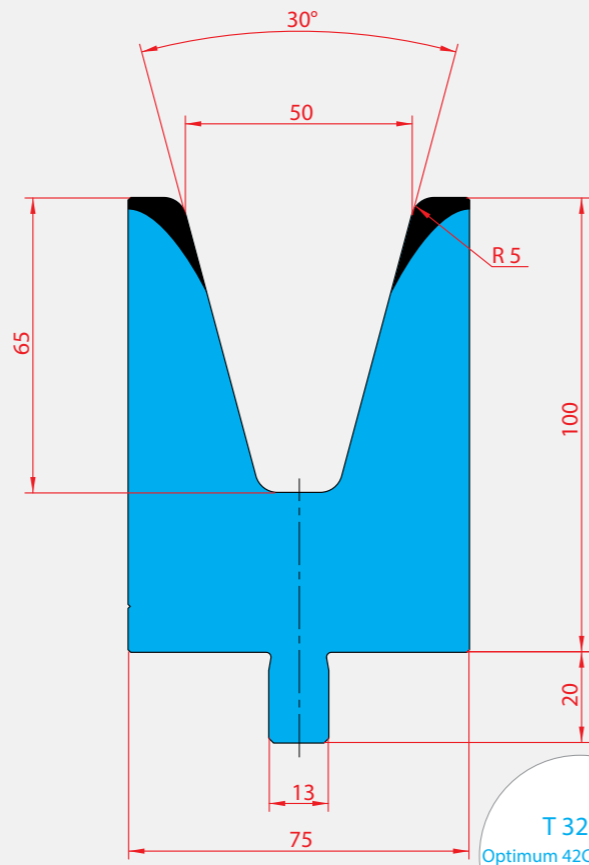
T 3237
Optimum 42CrMo4 Steel
Max T/m=40
EV002 R3



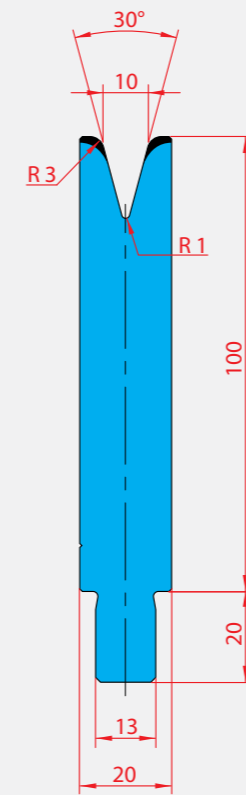
T 3214
Optimum 42CrMo4 Steel
Max T/m=73
EV W40/30°



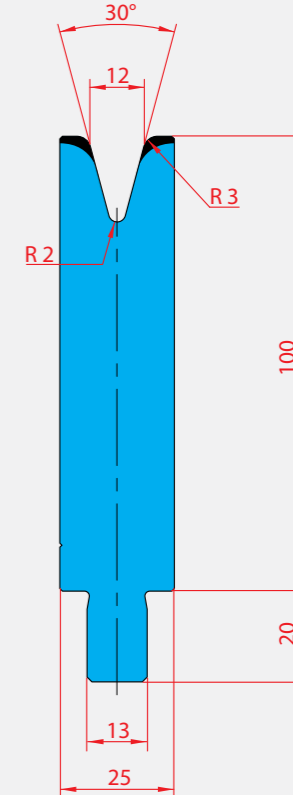
T 3235
Optimum 42CrMo4 Steel
Max T/m=50
EV W50/30°

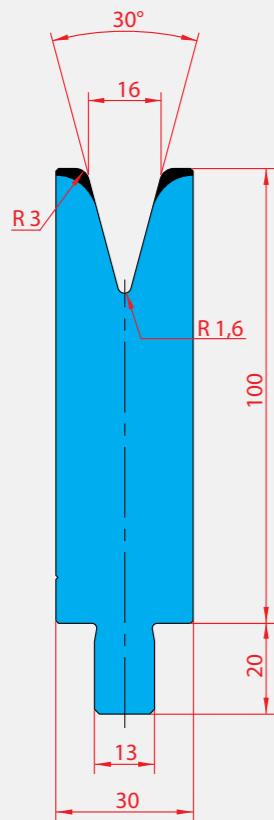


T 3238
Optimum 42CrMo4 Steel
Max T/m=30
EV003 R3



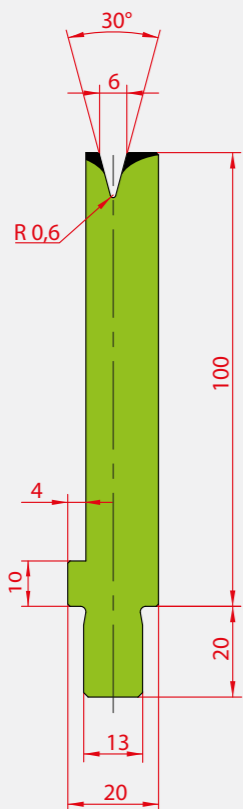
T 3239
Optimum 42CrMo4 Steel
Max T/m=40
EV004 R3



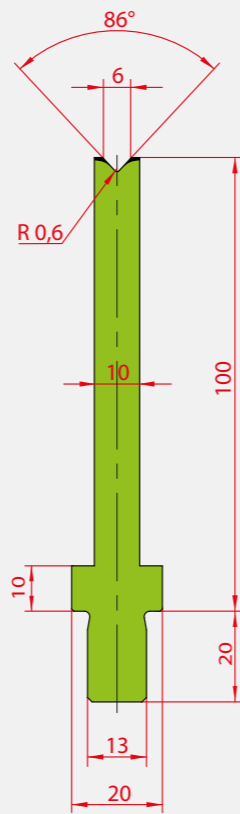


T 3240
Optimum 42CrMo4 Steel
Max T/m=40
EV005 R3

STANDARD
MODIFICATION
ON DEMAND

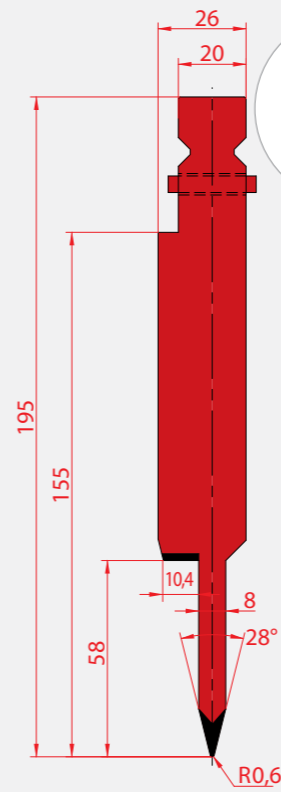


T 3206 SLIM
Standard C45
Max T/m=17



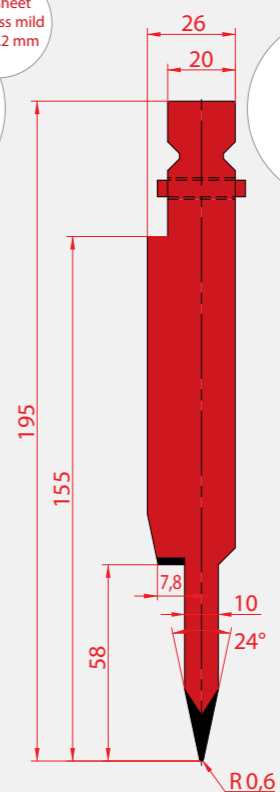
T 3200 SLIM
Standard C45
Max T/m=65

FLATTENING/
HEMMING
TOOLS



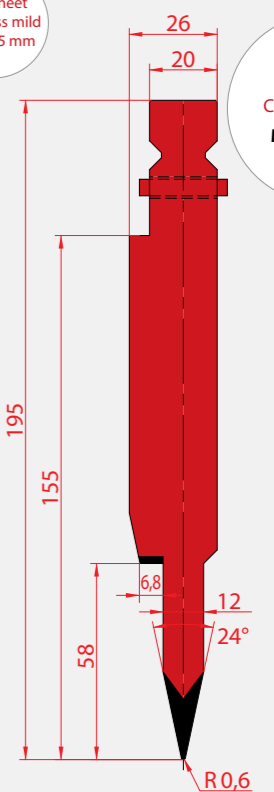
T 1249
C45 Quenched
Max T/m=80

Max sheet
thickness mild
steel 1,2 mm



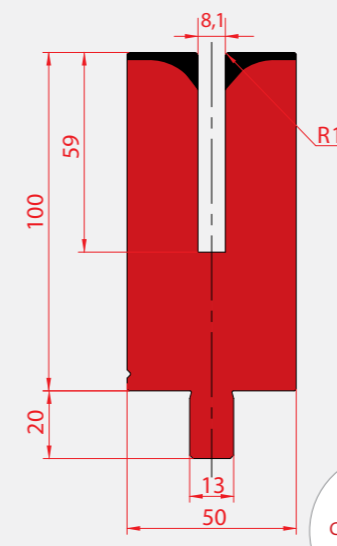
T 1250
C45 Quenched
Max T/m=80

Max sheet
thickness mild
steel 1,5 mm

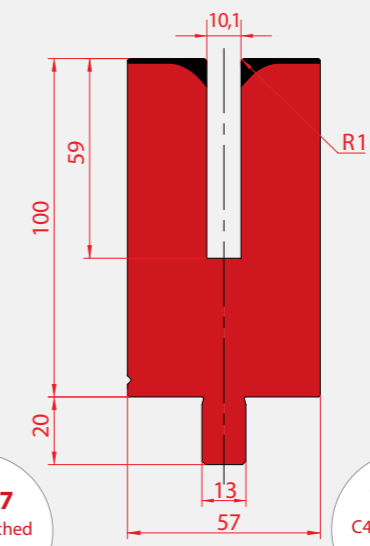


T 1251
C45 Quenched
Max T/m=80

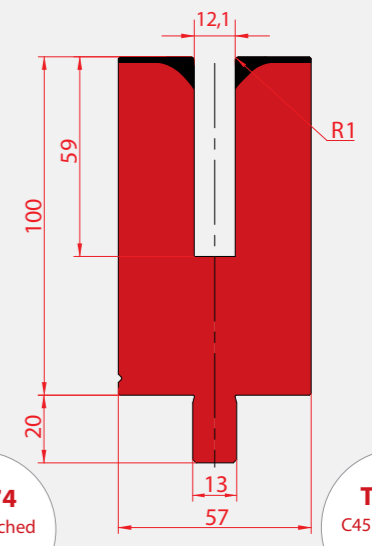
Max sheet
thickness mild
steel 1,5 mm



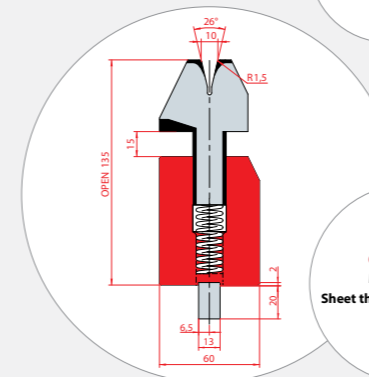
T 3157
C45 Quenched
Max T/m=50



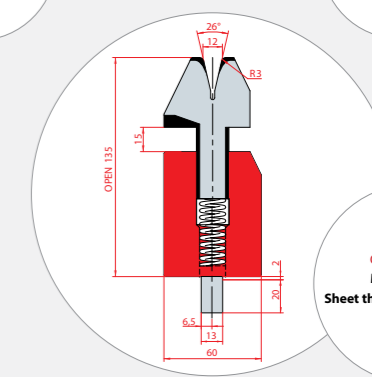
T 3174
C45 Quenched
Max T/m=50



T 3175
C45 Quenched
Max T/m=50



T 3038
C45 Quenched
Max T/m= 100
Sheet thickness= from 1,5 mm
to 2,5 mm



T 3040
C45 Quenched
Max T/m= 100
Sheet thickness= max 1,5 mm
to 3,0 mm

ACTIVE BEND

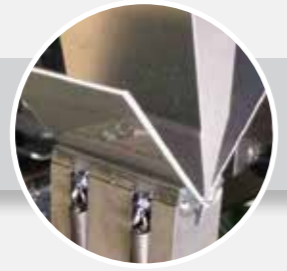


NEW TECHNOLOGY FOR HIGH QUALITY RESULTS

- Active Bend provides advantages that the standard dies can't perform:
- 40° acute bending
 - narrow minimum edges
 - no die marking (between sectioned pieces)
 - no strain with perforated sheets

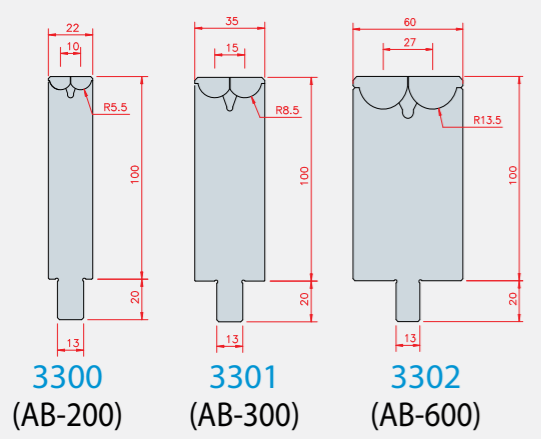
44

► NO DIE MARK BENDING



► 40° ACUTE BENDING

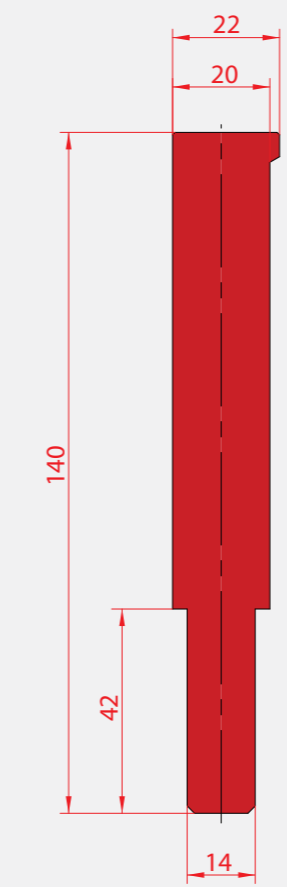
TRUMPF/ BYSTRONIC



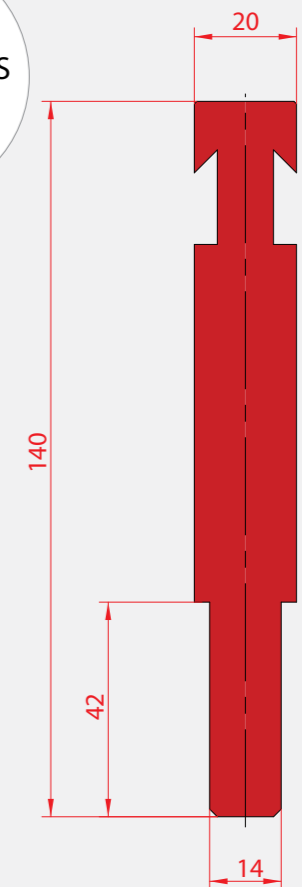
MODEL	LENGTH (mm)
AB200	50
	100
	200
	15, 20, 25, 30
AB300	50
	100
	200
	15, 20, 25, 30
AB600	50
	100
	200

45

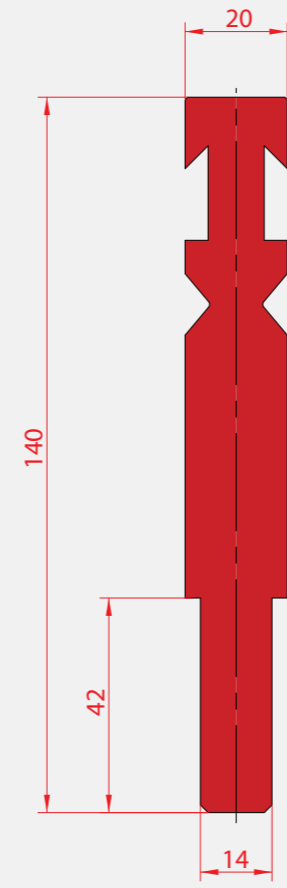
RADIUS TOOLS HOLDERS



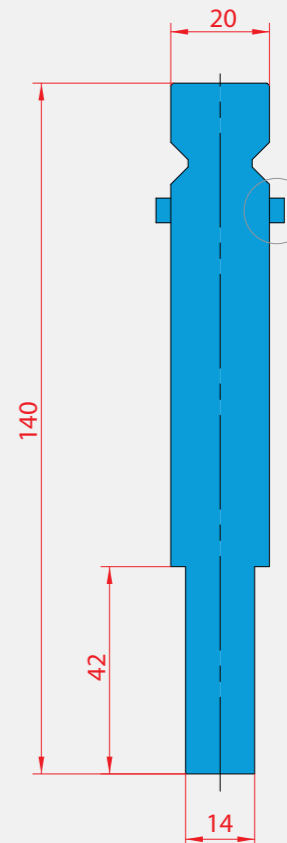
B 1241
C45 Quenched
Bystronic S
Max T/m=100



B 1239
C45 Quenched
Bystronic R
Max T/m=100



B 1273
C45 Quenched
Bystronic RF-A
Max T/m=100

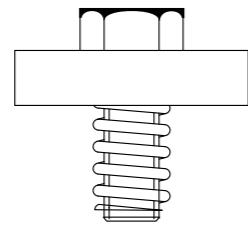


B 1240
Optimum 42CrMo4 Steel
Trumpf
Max T/m=100

SAFETY BUTTON AVAILABLE ON REQUEST WHEN THE WEIGHT OF THE PUNCH IS LESS THAN 12.5Kg

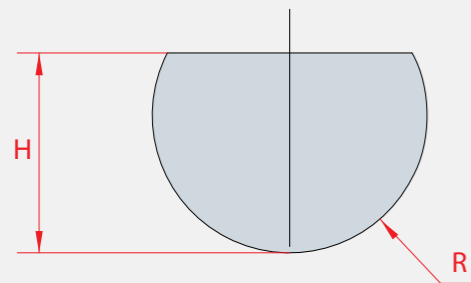
RADIUS TOOLS

AVAILABLE HARDENED

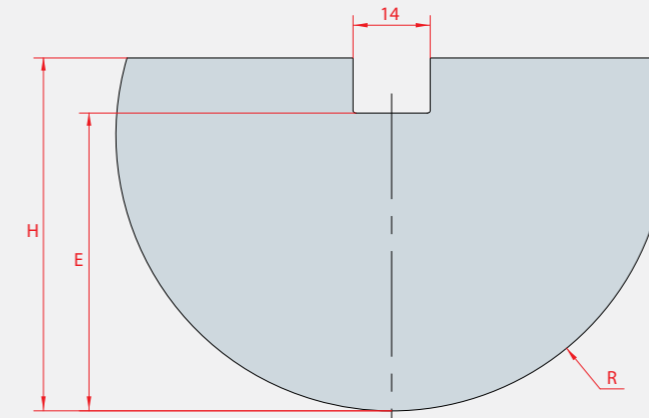


SPRING + SCREW + PLATE

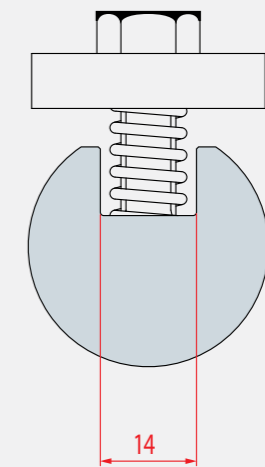
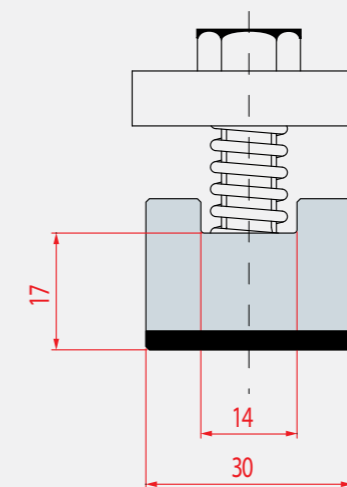
cod. 4274



	R	H
1100	7	11.5
1101	7.5	11.5
1102	8	13
1103	9	16
1037	10	16
1104	11	16
1105	11.5	16
1106	12	20



	R	H	E
1107	12.5	21	16
1108	13	23	17
1109	14	25	19
1038	15	27	20
1110	16	28	21
1111	17	31.5	21.5
1039	17.5	32	22
1112	19	32	25
1040	20	34	24
1113	22.5	33	25
1041	25	39	29
1114	27.5	44	34
1042	30	44	34
1115	35	55	45
1116	40	55	45
1117	45	60	50
1118	50	64	54



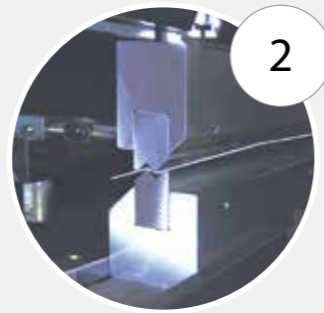
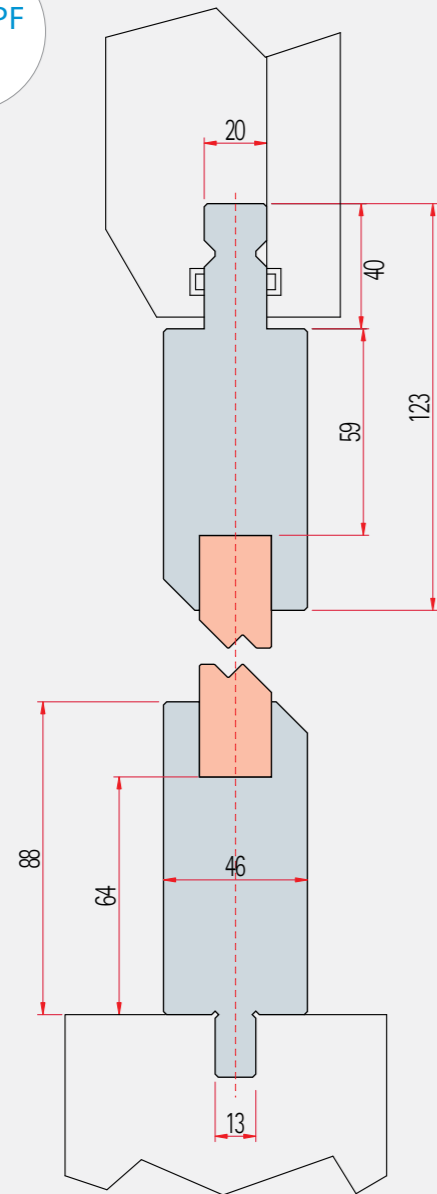
1043

46

47

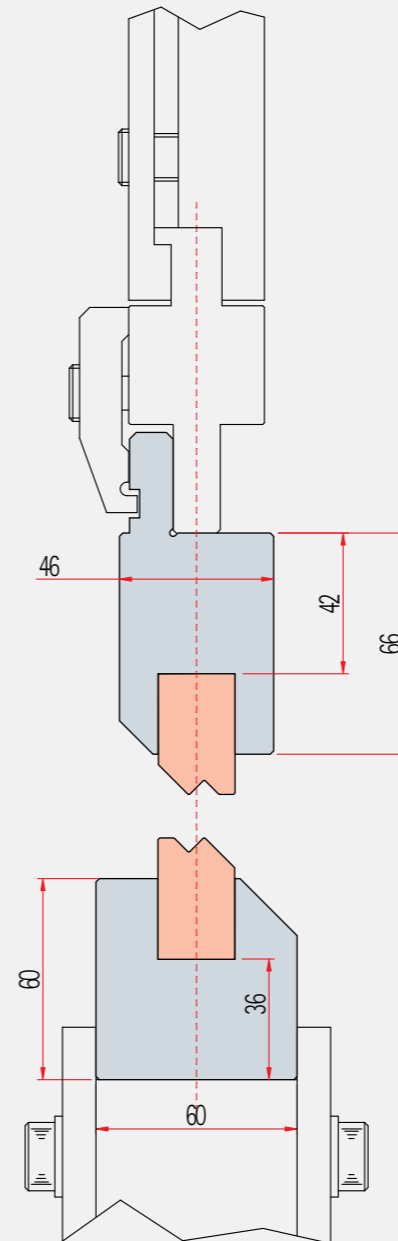
JOGGLE TOOLS

TRUMPF
1242



48

JOGGLE TOOLS

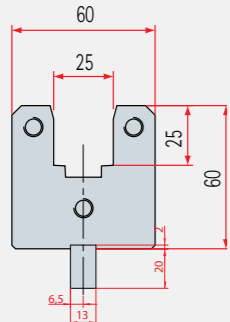


CODE	Z	DEGREES	MAX SHEET THICKNESS	L
1130	1	160°	0,5 mm	-
1276	1	90°	0,5 mm	-
1131	1,5	160°	0,6 mm	-
1277	1,5	90°	0,6 mm	-
1132	2	150°	0,8 mm	-
1274	2	90°	0,8 mm	-
1133	2,5	140°	1,0 mm	-
1275	2,5	90°	1,0 mm	-
1134	3	90°	1,0 mm	-
1135	3,5	90°	1,2 mm	-
1136	4	90°	1,2 mm	-
1137	4,5	90°	1,5 mm	-
1138	5	90°	1,5 mm	-
1139	5,5	90°	1,5 mm	-
1140	6	90°	1,5 mm	-
1141	6,5	90°	1,5 mm	-
1142	7	90°	2,0 mm	-
1143	7,5	90°	2,0 mm	-
1144	8	90°	2,5 mm	-
1145	9	90°	2,5 mm	27
1146	10	90°	3,0 mm	27
1147	11	90°	3,0 mm	27
1148	12	90°	3,0 mm	27
1278	13	90°	3,0 mm	32
1279	14	90°	3,0 mm	32
1280	15	90°	3,0 mm	32

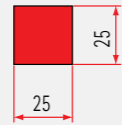
49

HOLDERS & POLYURETHANE INSERTS

2036

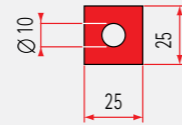


2101

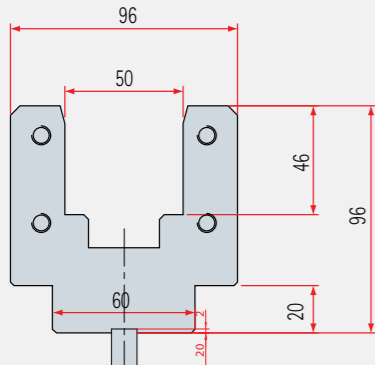


92 shore

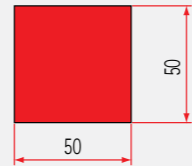
2105



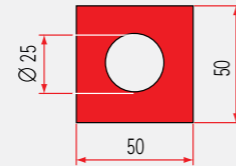
2037



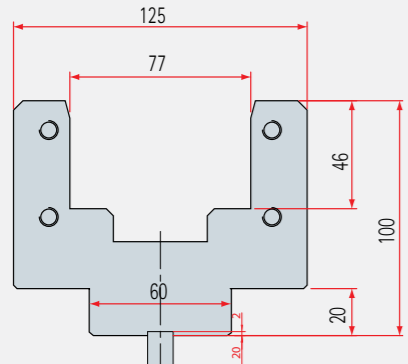
2102



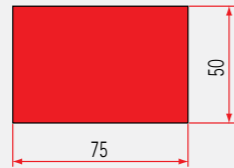
2106



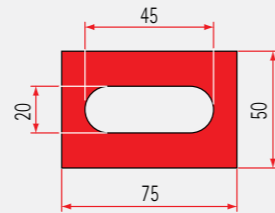
2038



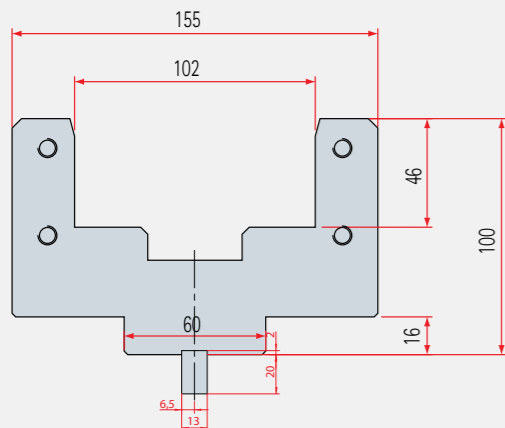
2103



2107



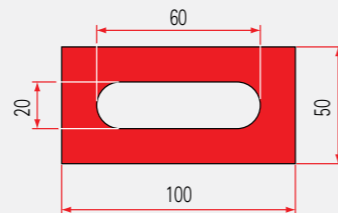
2040



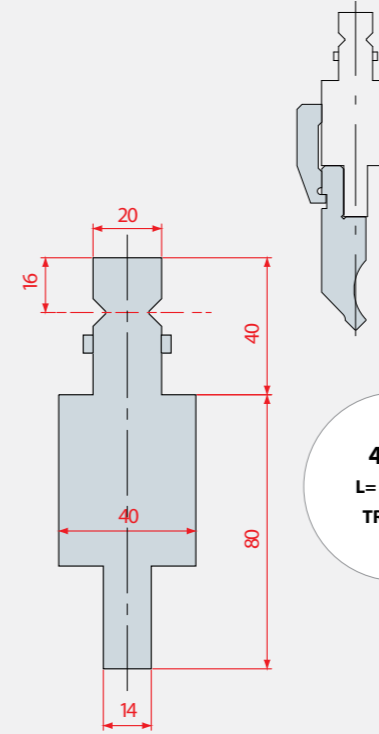
2104



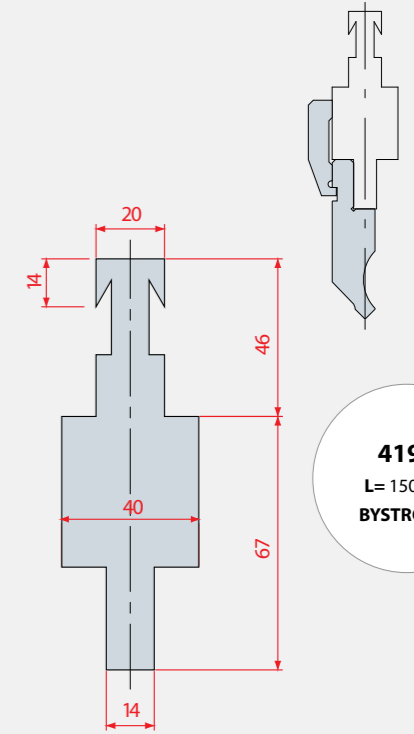
2108



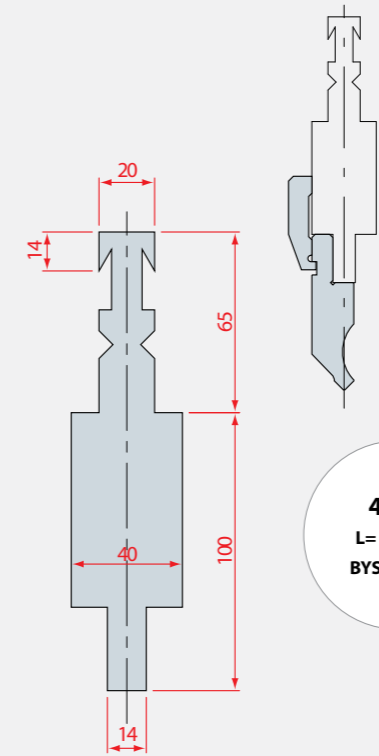
CONVERSION UNITS



4191
L= 150mm
TRUMPF



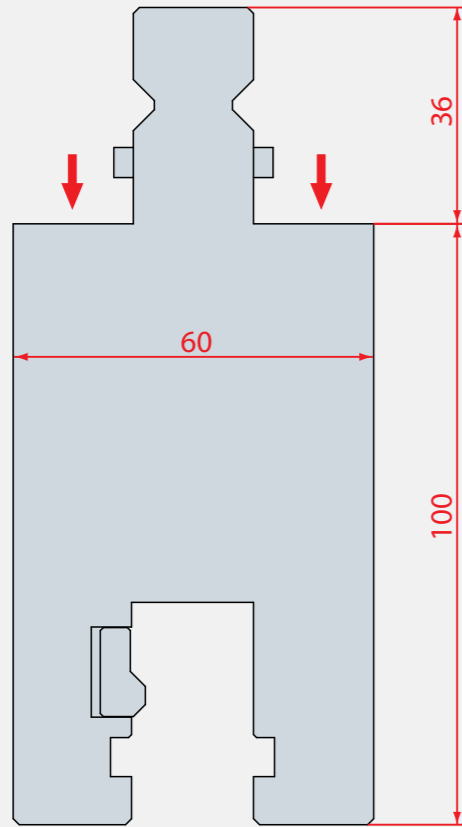
4192
L= 150mm
BYSTRONIC



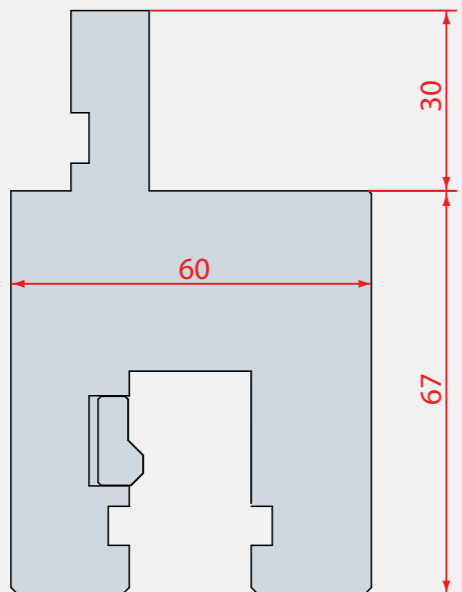
4214
L= 150mm
BYSTRONIC



ADAPTORS

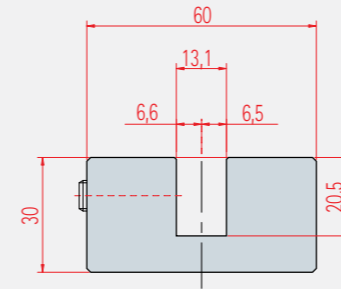


4361
H100 L=150
EXTENSION
TRUMPF

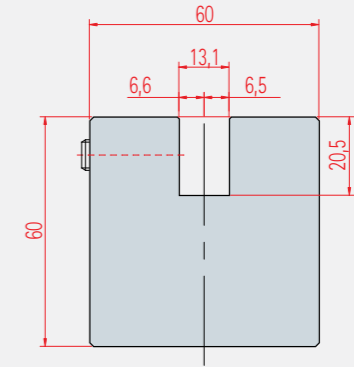
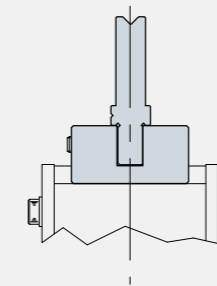


4362
H67 L=150
ADAPTOR
TRUMPF

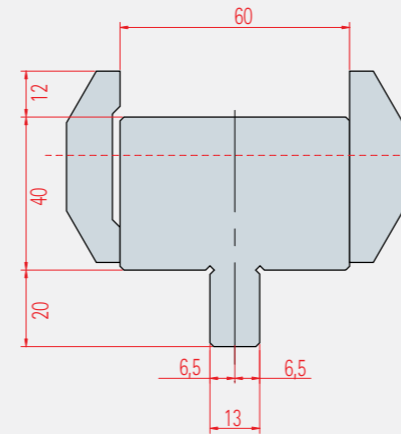
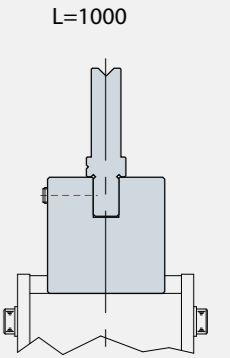
LOWER ADAPTORS



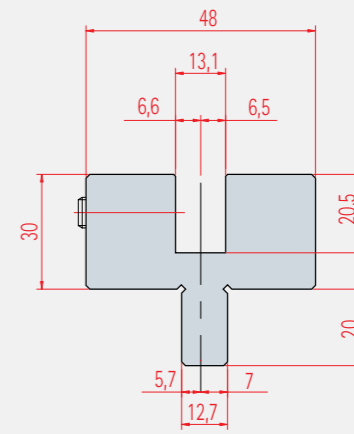
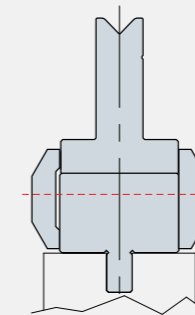
4301
L = 1000 mm
L = 500 mm
BYSTRONIC/TRUMPF



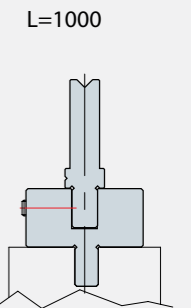
4302
L = 1000 mm
L = 500 mm
BYSTRONIC/TRUMPF



4303
L = 835 mm
L = 415 mm
BYSTRONIC/TRUMPF



4305
L = 1000 mm
L = 500 mm
BYSTRONIC/TRUMPF



ACCESSORIES

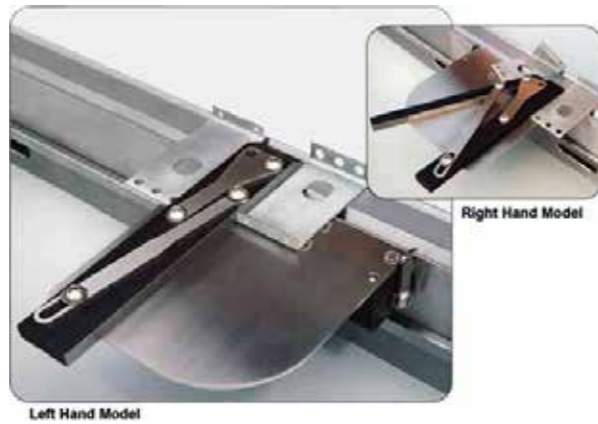


4309 COUPLE OF TIGHTENERS

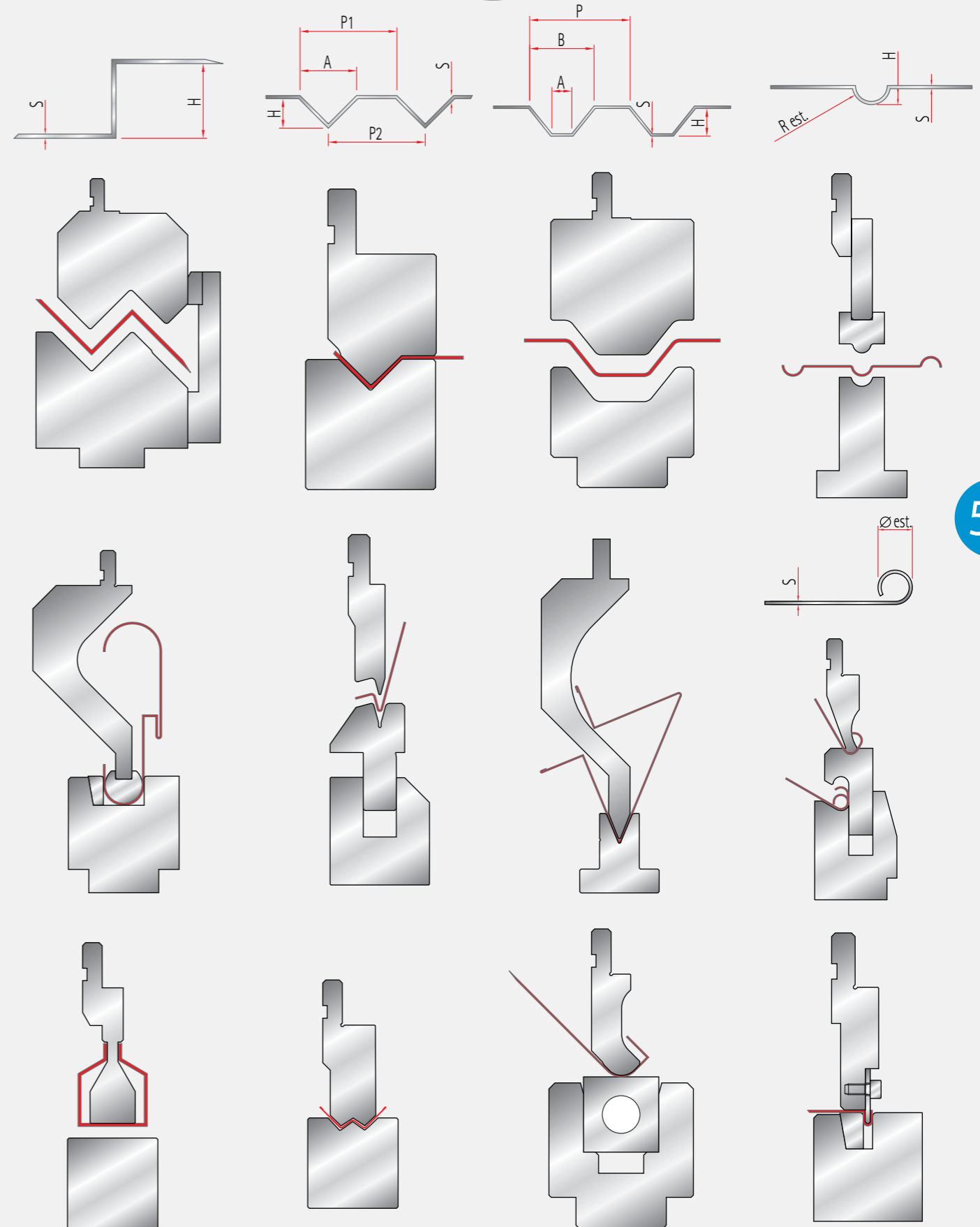


4308 FILM OF POLYURETHANE ANTISCRATCH 100 X 0,5 OF THICKNESS L = 30 MT

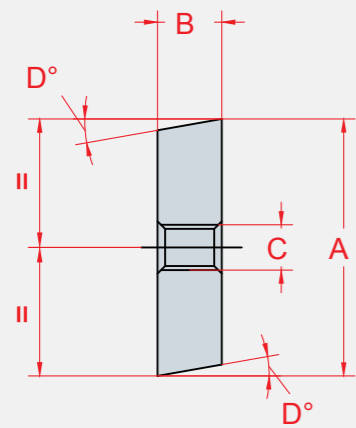
4314 FILM OF POLYURETHANE ANTISCRATCH 100X0,8 OF THICKNESS L = 30 MT



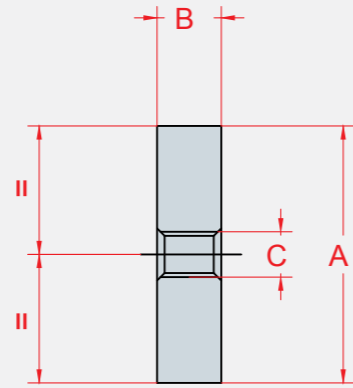
SPECIAL TOOLS ON REQUEST



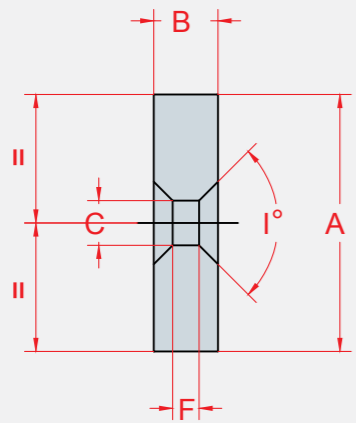
SHEAR BLADES



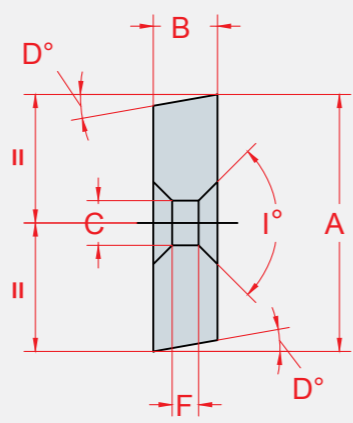
mod. 2000



mod. 2001



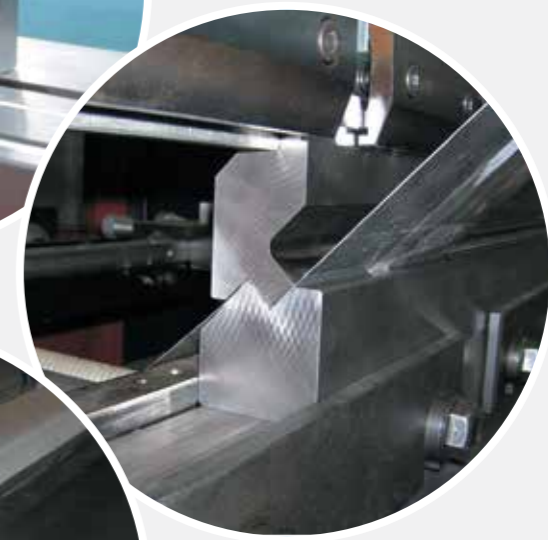
mod. 2004



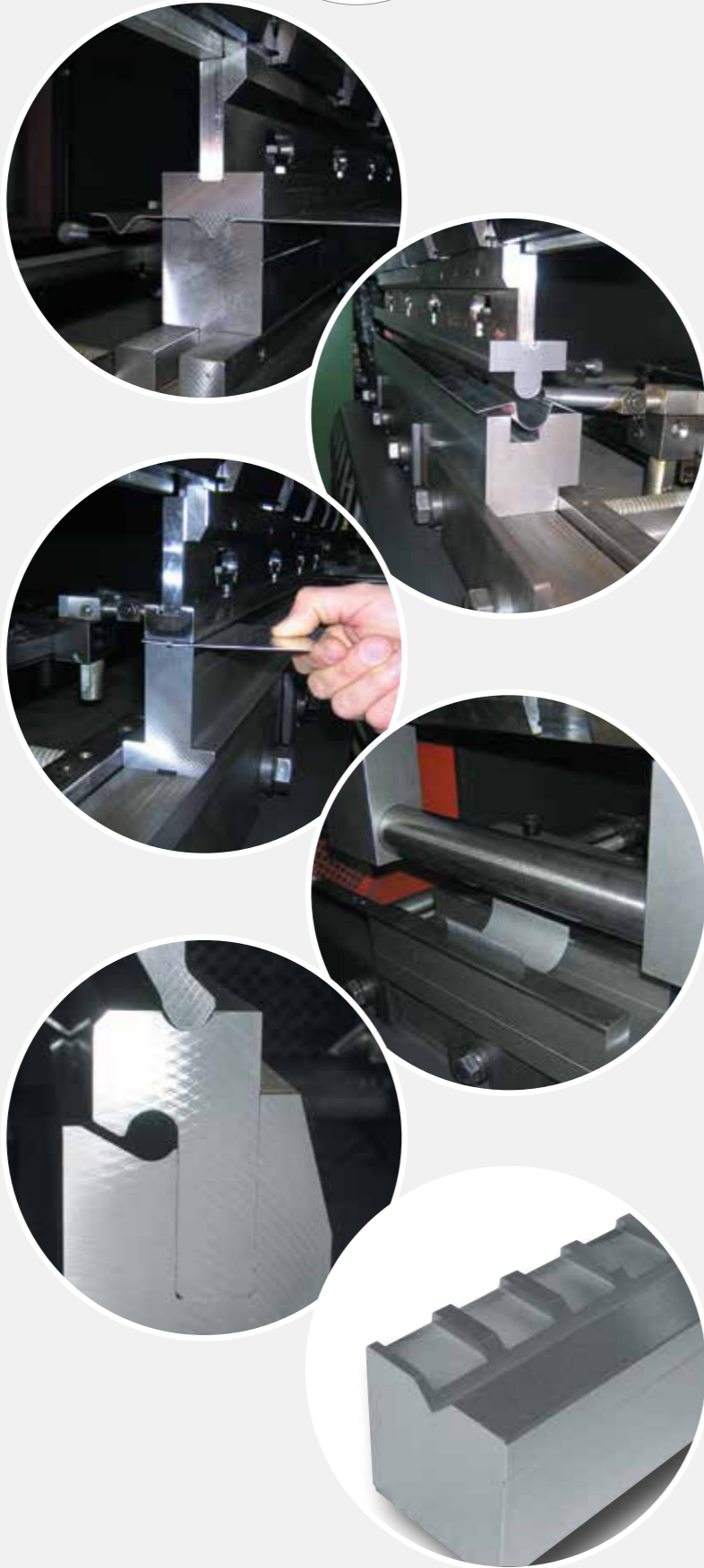
mod. 2005



EXAMPLE SPECIAL TOOLS



EXAMPLE SPECIAL TOOLS



MODIFICATION RADIUS

ASHMORES PRESS BRAKE TOOLING LTD		ANGLE a							
		90	88	86	60	45	35	30	26
REQUEST RADIUS	1	0,08	0,09	0,09	0,2	0,32	0,47	0,57	0,69
	1,5	0,29	0,31	0,33	0,7	1,13	1,63	2	2,41
	2	0,5	0,53	0,56	1,2	1,94	2,79	3,44	
	2,5	0,7	0,75	0,79	1,7	2,74			
	3	0,91	0,97	1,03	2,2				
	3,5	1,12	1,19	1,26	2,7				
	4	1,33	1,41	1,49					
	4,5	1,53	1,63	1,73					
	5	1,74	1,85	1,96					
	5,5	1,95	2,07	2,19					
6	2,15	2,29	2,42						
STARTING RADIUS: 0.8									

TOOLING CABINETS



TOOLING TROLLEY



ASHMORES PRESS BRAKE TOOLING LTD

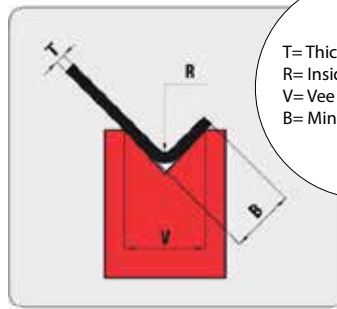
Tel: 0121 557 1064 Fax: 0121 557 1085

Email: ashmores@pressbraketool.co.uk Website: www.pressbraketool.co.uk

Lewis Street, Great Bridge, Tipton, West Midlands DY4 7EF.

T:Email: ashmores@pressbraketool.co.uk

Bending / Tonnage Charts



T= Thickness
R= Inside Radius
V= Vee size
B= Minimum leg length

T	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	320	400	V	
	4	5.5	7	8.5	11	14	17.5	22	28	35	45	55	71	89	113	140	175	226	350	B	
	1	1.3	1.6	2	2.6	3.3	4	5	6.5	8	10	13	16	20	26	32	41	53	83	R	
0.8	7	5	4																	F=T/m	
1	11	8	7	6																	
1.2	16	12	10	8	6																
1.5		17	15	13	9	8															
2			27	22	17	13	11														
2.5				35	26	21	17	13													
3					38	30	24	19	15												
4						54	42	34	27	21											
5							67	52	42	33	26										
6								75	60	48	38	30									
7									66	52	41	34									
8										86	69	53	43								
9											86	68	54	44							
10												105	85	67	53						
12													120	95	76	60					
15														150	120	95	75				
18															174	137	110	88			
20																170	135	108	85		
25																	210	170	130		105

For Aluminium Multiply answer by 0.6
For Stainless steel Multiply answer by 1.6